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DISTRIBUTION SHEET То From Page 1 of 1 DST Project & Maintenance Eng. Distribution Date 30 Aug 2005 Project Title/Work Order **EDT No.** 821994 Ultrasonic Inspection Results for Double-Shell Tank 241-AN-103 - FY 2005 ECN No. N/A Text Attach./ EDT/ECN Appendix Only Name MSIN With All Text Only Only Attach. RP Anantatmula R1-14 Χ R3-26 Χ JL Castleberry VL Callahan H6-60 Χ GP Duncan R3-26 Χ S5-07 BK Everett Χ TL Faust S5-03 Χ R1-14 Χ LJ Julyk PC Miller R1-51 S5-07 MJ Ostrom Χ Χ TC Oten S5-07 R1-14 RL Schlosser Χ BH Thacker S5-10 Χ R1-14 Х TC Mackey S5-07 Χ MA Haq

ULTRASONIC INSPECTION RESULTS FOR DOUBLE-SHELL TANK 241-AN-103 - FY 2005

CHRIS E. JENSEN

CH2M HILL HANFORD GROUP, INC.

Richland, WA 99352

U.S. Department of Energy Contract DE-AC27-99RL14047

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Abstract: This report documents the ultrasonic examination of 241-AN-103. There was no reportable wall thinning or pitting detected in any of the plate areas examined - both vertical and horizontal examinations. The greatest thinning identified was 6% of nominal wall thickness in Plate 3. There were no cracklike indications or pitting identified in any of the weld heat affected zones examined.

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ULTRASONIC INSPECTION RESULTS FOR DOUBLE-SHELL TANK 241-AN-103 – FY 2005

C.E. Jensen

CH2M HILL Hanford Group, Inc.

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Ultrasonic Inspection Results for Double-Shell Tank 241-AN-103 – FY 2005

June 2005

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Prepared for:

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TERMS								
AATT ASME CH2M HILL CHAMPS	Absolute Arrival Time Technique American Society of Mechanical Engineers CH2M HILL Hanford Group, Inc. Computerized History and Maintenance Planning System							
COGEMA Engineering dB	COGEMA Engineering Corporation Decibel							
DSC	Distance Sensitivity Calibration							
DST	Double-shell tank							
DSTIP	Double-Shell Tank Integrity Project							
EPRI	Electric Power Research Institute							
FSH	Full Screen Height							
FY	Fiscal Year							
HAZ	Heat-Affected Zone							
IIW	International Institute of Welding							
MHz	Megahertz							
NDE	Nondestructive Examination							
PDT	Performance Demonstration Test							
PNNL	Pacific Northwest National Laboratory							
RATT	Relative Arrival Time Technique							
RL	U.S. Department of Energy, Richland Operations Office							
RMS	Root Mean Square							
T-SAFT	Tandem Synthetic Aperture Focusing Technique							
TWINS	Tank Waste Information Network System							
TWRS	Tank Waste Remediation System							
UT	Ultrasonic Testing							
WDOE	Washington State Department of Ecology							

EXECUTIVE SUMMARY

Background

Through FY 1999, six double-shell tanks were ultrasonically examined to meet the integrity requirements of the *Washington Administrative Code*, Chapter 173-303, "Dangerous Waste Regulations". Subsequent to the examinations, integrity assessment reports were issued for each double-shell tank farm and submitted to the Washington State Department of Ecology (WDOE) in FY 1999. In June 2000, the Washington State Department of Ecology issued Administrative Orders 00NWPKW-1250 and 00NWPKW-1251 providing prescriptive examination requirements for all double-shell tanks by FY 2005. In 2003, the Administrative Orders were incorporated into the Hanford Federal Facility Agreement and Consent Order, Milestones Series M-48. Milestone M-48-13 requires examination by September 30, 2005, of four DSTs not previously examined. This report documents the required ultrasonic examination of double-shell tank 241-AN-103, completed in the third quarter of FY 2005.

Methodology

The primary tank wall examinations consisted of two parallel 15-inch wide strips, ~35 feet in length (scanned vertically), a horizontal 17 inch by 240 inch strip encompassing the historical liquid-air interface, and a horizontal 15-17 inch by 240 inch vapor space strip above the historical liquid-air interface. The primary wall vertical examinations were looking for wall thinning, cracking, and pitting in the tank wall. The weld heat affected zones (HAZ) examined included 25.1 linear feet of vertical welds joining plates 2 through plate 5, and 19.9 linear feet of the horizontal plate #5 to knuckle weld.

The ultrasonic examinations were carried out in accordance with American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code, Section V, "Nondestructive Examinations". The personnel and non-destructive examination equipment were qualified to perform the examinations on the double-shell tanks by performance demonstration tests administered by Pacific Northwest National Laboratories.

The required accuracy for the ultrasonic examinations is to be within 0.020 inches for wall thinning, 0.050 inches for pitting, and 0.10 inches for cracking. The performance demonstration tests revealed that the examiners meet this requirement.

Results

There was no reportable wall thinning detected in any of the plate areas examined (reportable wall thinning is defined as greater than 10% below nominal). The primary wall vertical scans yielded an overall average ((scan 1 + scan 2)/2) wall thickness value of 103.5% of nominal. The overall average ((scan 1 + scan 2)/2) minimum wall thickness value was 99.2% of nominal. Of the 12 inch long vertical wall plate scans yielding minimums falling below the nominal values, the greatest deviation was 6.0% below the nominal (Plate #3, Scan 2).

There were no reportable pitting indications nor any crack-like indications detected in any of the wall plates.

There were no areas of reportable wall thinning, cracking, or pit-like indications detected during the primary tank horizontal wall scan of the historical liquid-air interface, nor were there any areas of reportable wall thinning, cracking, or pit-like indications detected during the primary tank horizontal wall scan of the vapor space above the historical liquid-air interface.

The average horizontal wall thickness value was 107.9% of nominal for the vapor space scan, and 109.7 of nominal for the liquid-air scan. The average minimum horizontal wall thickness value was 101.5% of nominal for the vapor space scan, and 103.6% of nominal for the liquid-air scan. Of the 12 inch long horizontal wall plate scans yielding minimums falling below the nominal value (0.500 inches), the greatest deviation was 4.8% below the nominal for the vapor space scan, and 6.0% below the nominal for the liquid-air scan.

There were no areas of reportable wall thinning, no crack-like indications, nor reportable pitting indications detected in any of the weld HAZ. This included the primary tank vertical weld scans, and the primary tank lower knuckle-to-shell horizontal weld scan. The average HAZ thickness value was 101.1% of nominal for the vertical weld HAZ, and 103.7% of nominal for the horizontal knuckle/plate weld HAZ. The average minimum HAZ thickness value detected was 96.2% of nominal for the vertical welds HAZ, and 100.5% of nominal for the horizontal weld HAZ. Of the 12 inch long HAZ scans yielding minimums falling below the nominal values, the greatest deviation was 9.0% below nominal for the vertical welds HAZ, and 5.3% of nominal for the horizontal weld HAZ.

Conclusions

Based on the results of this examination (no reportable indications), the material condition of DST AN-103 is satisfactory for continued operation.

The tanks inspected to date are summarized in the following table.

Double-Shell Tanks Inspected Through May 2005

Double-	Inspection Year (FY)										
Shell Tank	1997	1998	1999	2000	2001	2002	2003	2004	2005		
AN-101						х					
AN-102					х						
AN-103	_								х		
AN-105			Х			(1)					
AN-106			х								
AN-107		Х									
AP-101							X (3)				
AP-102			-					·	Х		
AP-103							X (4)				
AP-104	Î							х	(1)		
AP-105					,,,,		х	****			
AP-106									х		
AP-107				х					","		
AP-108				Х		(2)					
AW-101					х						
AW-102						х	(5)		·		
AW-103	Х										
AW-104						Х					
AW-105					Х				<u> </u>		
AW-106						х					
AY-101					x	х	(1)				
AY-102			х						****		
AZ-101			х								
AZ-102					• h.		X (3)				
SY-101								x			
SY-102								x			
SY-103								X			

⁽¹⁾ Limited scope reexamination.

⁽²⁾ Linear indication evaluated.

⁽³⁾ Includes primary knuckle Synthetic Aperture Focusing Technique (T-SAFT) examination.

⁽⁴⁾ Linear indication detected; A follow-up inspection determined that it is a small area of incomplete fusion.
(5) Primary knuckle T-SAFT examination only.

1.0 INTRODUCTION

In May 1996 the Tank Waste Remediation System (TWRS) Decision Board recommended, and U.S. Department of Energy, Richland Operations Office (RL) agreed, that the condition of the double-shell tanks (DST) should be determined by ultrasonic testing (UT) inspection of a limited area in six of the 28 DSTs (Figure 1-1). The Washington State Department of Ecology (WDOE) agreed with the strategy of limited ultrasonic inspection of DSTs. Data collected during the UT inspections will be used to assess the condition of the tank, judge the effects of past corrosion control practices, and satisfy a regulatory requirement to periodically assess the integrity of waste tanks.

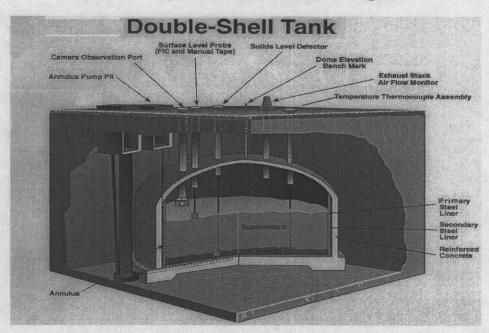


Figure 1-1. Typical Double-Shell Tank Configuration

In November 1996, DST 241-AW-103 was the first tank inspected to determine if Hanford DST walls could be inspected without removing the existing surface rust and scale. Equipment similar to that used to perform routine inspections of oil tanks and large pipelines was used. UT sensors were mounted on a remote-controlled crawler that used magnetic wheels to affix itself and move about on the tank walls. The crawler was deployed into the tank annulus and vertically traversed the primary and secondary containment walls to collect data on the wall thickness and the size of any pits or cracks. The successful completion of this inspection met the requirements of RL Milestone T21-97-455 and represented the first UT inspection of a Hanford DST (Final Report - Ultrasonic Examination of Tank 241-AW-103 Walls, Leshikar 1997).

In fiscal year (FY) 1998, FY 1999, and FY 2000, similar inspections were performed per Engineering Task Plans HNF-2820 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks, Pfluger 1999) and RPP-5583 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2000, Jensen 2000) on 241-AN-107, 241-AN-106, 241-AN-105, 241-AY-102, 241-AZ-101, 241-AP-107, and 241-AP-108. An

attempt was made to examine 241-AY-101 in FY 1999, but corrosion product on the tank wall prevented reliable examination.

In June 2000, WDOE issued an Administrative Order requiring UT examinations of the remaining 20 DSTs through FY 2005 (Administrative Order No. 00NWPKW-1251, Failure to Comply with Major Milestone M-32 of the Tri-Party Agreement, Silver 2000). In 2003, the WDOE Administrative Order (Silver 2000) was incorporated into the Hanford Federal Facility Agreement and Consent Order Milestone Series M-48 (HFFACO 2003), requiring examination during each FY through FY 2005 of four DSTs not previously examined. Based on the results of the above listed eight DST inspections and per the Milestone Series M-48 (HFFACO 2003), engineering task plans were prepared for ultrasonic DST inspections scheduled for the subsequent fiscal years.

In FY 2001, UT inspections were performed on four DSTs: 241-AN-102, 241-AW-101, 241-AW-105, and 241-AY-101 (following cleaning of selected areas of the 241-AY-101 wall). These DSTs were examined per Engineering Task Plan RPP-6839 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2001, Jensen 2000a).

In FY 2002, UT inspections were performed on four more DSTs: 241-AN-101, 241-AW-102, 241-AW-104, and 241-AW-106. Also in FY 2002, a more extensive examination of 241-AY-101 was performed, and an examination of 241-AP-108 was limited to characterization of the linear indication found in FY 2000. In addition, a limited scope reexamination of the upper walls of tank 241-AN-105 was performed in FY 2002. These DSTs were examined per RPP-7869 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2002, Jensen 2002), and RPP-8867 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks 241-AP-108, 241-AY-101, and 241-AZ-102 - FY2002, Jensen 2002a).

In FY 2003, UT inspections were performed on four more DSTs: 241-AP-101, 241-AP-103, 241-AP-105, and 241-AZ-102. Also, a primary tank lower knuckle inspection on 241-AW-102 using the Tandem Synthetic Aperture Focusing Technique (T-SAFT) not completed during FY 2002 was completed in early FY 2003. In addition, a supplementary, limited scope examination of the tank 241-AY-101 secondary tank wall was completed. These DSTs were examined per RPP-11832 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2003, Jensen 2002b).

In FY 2004, UT inspections were performed on four more DSTs: 241-SY-101, 241-SY-102, 241-SY-103, and 241-AP-104. A limited scope examination of tank 241-AN-105 originally planned for FY 2004 was deferred until FY 2005. These DSTs were examined per RPP-17750 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2004, Jensen 2003).

In FY 2005, UT inspections were planned on four more DSTs: 241-AN-103, 241-AN-104, 241-AP-102, and 241-AP-106. Limited scope examinations of tanks 241-AN-101, 241-AN-105, 241-AP-104 and 241-SY-101 were also planned for FY 2005. These DSTs were to be examined per RPP-22571 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2005, Jensen 2005).

DST 241-AN-103 was the third of the four tanks selected for standard inspection in FY 2005 (tanks 241-AP-102 and 241-AP-106 examinations have been completed). Inspection of tank 241-AN-103 was completed in the third quarter of FY 2005, and is the subject of this report. The services of COGEMA Engineering Corporation (COGEMA Engineering) were retained to provide UT examinations, procedures and inspectors, and to report the inspection results. Examination of 241-AN-103 was performed with UT equipment provided by CH2M HILL Hanford Group, Inc. (CH2M HILL).

2.0 OBJECTIVE AND SCOPE

This report describes the inspection system, evaluates the inspection results, and documents findings with conclusions and recommendations. The UT inspections described in this report include the primary tank wall, the historical liquid-air interface, the vapor space above the historical liquid-air interface, the vertical weld HAZ, and the horizontal cylinder/knuckle weld HAZ.

3.0 INSPECTION EQUIPMENT DESCRIPTION

Crawler / Scanning Bridge Systems – The crawler is a remotely controlled device that delivers the ultrasonic transducers to the tank walls. The crawler used during most P-scan imaging weighs approximately 35 pounds and has dimensions (including its traveling bridge) of approximately 21 inches wide by 18 inches long by 6 inches high. The traveling bridge on the crawler can be outfitted with various ultrasonic transducer configurations (Figure 3-1).

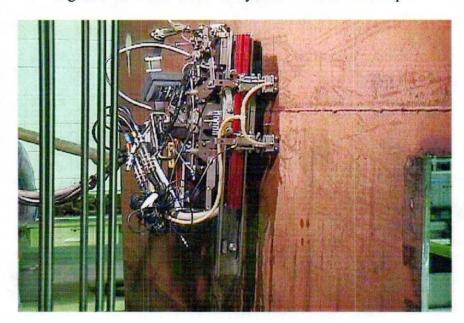


Figure 3-1. P-scan Crawler System on Tank Mock-up

The crawler is deployed through a 24 inch annulus inspection riser using customized deployment tools. The P-scan tank wall crawler attaches to the tank wall with two pairs of magnetic wheels. As the crawler moves slowly forward the transducers glide from side-to-side over the tank wall surface. Water couplant is continuously fed to all transducers at a rate needed to maintain an acceptable signal.

Deployment Tools – A deployment tool was specifically designed to insert and retrieve each scanning system into and out of the DST annular space. The scanner sits on a platform that is manually lowered to the appropriate elevation. The platform has cables attached that can be controlled to move the scanner platform into contact with the examination surface or to the secondary tank floor. The scanner is then driven onto the surface or the tank floor. The deployment tool is retracted until the scanner needs to be removed from the annular space.

P-scan – P-scan is the name of the computerized pulse-echo ultrasonic inspection system used by the inspection vendor. The P-scan system is manufactured by Force Institute in Denmark. It acquires data from zero and angle beam transducers mounted on the crawler, allows real-time analysis, and records the data in electronic memory for post inspection analysis. Force Institute has designated "P-scan mode" to represent the angle beam (flaw length) view and "T-scan

mode" to represent the zero beam (thickness) view. T-scan mode is used for normal operation and, if crack-like indications are detected, then the P-scan mode is employed.

During normal T-scan and P-scan operations, the waveforms of the reflected sound wave signals for each transducer are displayed in the "A-scan monitoring mode". The displays are continuously monitored (but not saved), and are primarily used to verify that the transducers are functioning properly (e.g., there is proper probe contact, adequate water flowing, and correctly operating transducer cables). When an indication is detected, the area is rescanned using the "A-scan recording mode". The recorded A-scan waveforms are then reviewed off-line, serving as an additional tool in the evaluation of the indication.

Overview Camera – This camera was deployed to observe the area immediately around the inspection area and to aid crawler deployment in the annulus.

Side-view Camera – This camera and light system were installed in a riser adjacent to the inspection riser to provide an overall view of the inspection process.

Data Acquisition Control Center – A pull-type trailer was used to house the crawler controls, video monitors, and data collection and evaluation hardware. The trailer was located outside the AN Tank Farm boundary fence.

4.0 UT INSPECTION DESCRIPTION

The following is the description of the data collection methodology:

Tank inspection was performed under Computerized History and Maintenance Planning System (CHAMPS) work package number WFO-04-0147. All work steps, guidelines, procedures, personnel responsibilities, and protocol for the inspection (Jensen 2005) were included in the subject work package. The COGEMA Engineering procedure that establishes the methods, equipment and requirements for the UT measurements and flaw detection is *Automated Ultrasonic Examination For Corrosion And Cracking*, COGEMA-SVUT-INS-007.3 (Attachment 1).

<u>P-scan Crawler for Tank Walls and Knuckle</u> - A remotely controlled, steerable crawler was used to deliver the P-scan UT transducers to the tank wall (Figure 3-1). The crawler was deployed through the 24 inch diameter annulus inspection Riser Number 025 to perform the vertical wall scans, the horizontal wall scans, and the vertical and horizontal weld scans.

The P-scan crawler inspects the primary tank wall using one dual-element 0° transducer to detect wall thinning and corrosion pitting, and two 45° shear-wave transducers to detect cracking transverse to the scanning direction. This examination setup is illustrated in the Figure 4-1 schematic.

Top View (Transducers Only) Side View Crawler Crawler Scan Scan Travel Travel Direction Direction Direction Direction X Bridge Fixture Transducers Tank Wall 45 45° 45° Angle-beam 0° Straight-beam Transducers Transducer Tank Wall

Figure 4-1. Schematic of UT Setup for Vertical Wall Inspection

Vertical Wall Inspection Setup – Uses two 45° Transducers and one 0° Transducer (Inspect for Wall Thinning, Pitting and Axial Cracks)

Note that the examination of the welds and HAZ actually consist of angle beam examinations in the HAZ. The welds are not directly examined since the physical configuration does not permit transducer placement on the weld. This physical configuration is the weld crown. The DSTs

were not designed or fabricated for in-service inspection, and therefore the weld crowns were not prepared for examination.

To detect cracks parallel to the weld, a 60° shear-wave transducer was directed toward the weld and a dual-element 0° transducer is also included to detect wall thinning and corrosion pitting (Figure 4-2). The examination of the HAZ using 60° angle beams will provide some coverage of the actual weld to the inside surface. For example, in a previous UT examination, a "lack of fusion" in a weld was identified (*Ultrasonic Inspection Results for Double-Shell Tank* 241-AP-103, Jensen 2003a).

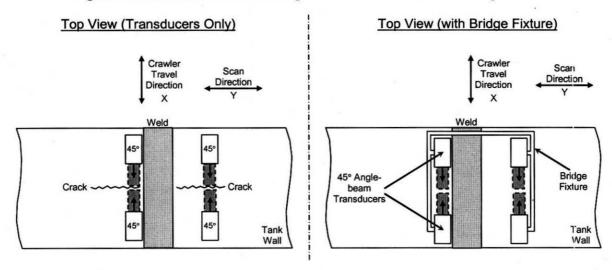
Top View (Transducers Only) Side View Crawler Crawler Scan Travel Direction Direction Direction X **Bridge Fixture** Transducers Transducers Weld Tank 60° Wall (00 0° Straight-beam 60° Angle-beam Transducer Transducer Tank Wall Cracks

Figure 4-2. Schematic of UT Setup for First Pass of Weld Inspections

First Pass of Vertical and Horizontal Weld Inspection – Uses two 60° Transducers and two 0° Transducers (Inspect for Wall Thinning, Pitting and HAZ Cracks Parallel to the Weld)

To detect cracks oriented perpendicular to welds, two opposing 45° shear-wave transducers were directed parallel to the weld. Welds were examined from both sides of the weld crown (Figure 4-3).

Figure 4-3. Schematic of UT Setup for Second Pass of Weld Inspections



Second Pass of Vertical and Horizontal Weld Inspection – Uses four 45° Transducers (Inspect for HAZ Cracks Perpendicular to the Weld)

Data and images from the P-scan system were returned to a nearby control center located outside the tank farm fence. The control center contained the crawler controls, video monitors, and data collection and evaluation software and hardware. The UT inspector continuously monitored the signals for reportable indications.

5.0 INDICATION REPORTING CRITERIA

COGEMA Engineering was required to report to the customer the following anomalies:

- Wall thinning that exceeded 10 percent of the nominal wall thickness
- Pit depths that exceeded 25 percent of the nominal wall thickness
- Cracks that exceeded 0.1 inch in depth

The reporting criteria is established to identify indications that should be tracked. This tracking is to be used to determine if there is any active mechanism causing additional thinning, pit growth, or crack growth, based on subsequent examinations on the eight to ten year examination interval. The values are nominally 50% of the "acceptance criteria" established in *Acceptance Criteria for Non-Destructive Examination of Double-Shell Tanks* (Jensen 1995) and recommended in *Guidelines for Development of Structural Integrity Programs for DOE High-Level Waste Storage Tanks* (Bandyopadhyay et al. 1997).

For indications exceeding the "acceptance criteria", actions are initiated to evaluate the operability of the DST (Jensen 2005) through the occurrence reporting process. Indications exceeding the "reporting criteria" are reported to the CH2M HILL Project Engineer to be documented in the inspection report (Jensen 2005).

6.0 PERFORMANCE DEMONSTRATION TESTS

Prior to field use, COGEMA Engineering personnel satisfactorily completed a Performance Demonstration Test (PDT). The test was conducted to qualify personnel, test procedures, and ensure the equipment's ability to detect and size wall thinning, pits, and cracks in a series of test plates with artificial defects. The performance demonstration test was performed on a tank mock-up in the 306E Facility located in the Hanford Site 300 Area. This mock-up also demonstrated the successful deployment and retrieval of the equipment.

The Pacific Northwest National Laboratory (PNNL) report, "Report on Performance Demonstration Test – PDT, May 2000" (Attachment 3 of Ultrasonic Inspection Results of Double-Shell Tank 241-AP-108, Jensen 2000b) provides the details of the complete evaluation of the P-scan system PDT.

7.0 TANK 241-AN-103 HISTORY

The 241-AN Tank Farm consists of seven DSTs located in the 200 East Area of the Hanford Site. These underground tanks were built in 1980 and 1981, and are 75 feet in diameter with an operating capacity of 1.16 million gallons.

Tank 241-AN-103 entered service in the first quarter of 1982, receiving raw water. The tank received non-complexed waste from tank 241-SY-102 and water from miscellaneous sources during the fourth quarter of 1982. Waste was sent to tank 241-AW-102 during the fourth quarter of 1982 and the first quarter of 1983. Non-complexed waste from the 300 and 400 Areas was sent to the tank during the third quarter of 1983.

In the third quarter of 1983 and 1984, the tank received liquid from the saltwell pumping of several single-shell tanks in the 200 East and West Areas. The tank also received non-complexed waste from B Plant cesium processing during the first quarter of 1984.

Non-complexed waste from tank 241-AN-104 and water from miscellaneous sources was sent to the tank during the third quarter of 1984. Tank 241-AN-103 sent waste to tank 241-AN-101 during the fourth quarter of 1984. Tank 241-AN-103 exchanged non-complexed waste with tank 241-AW-102 during the first and fourth quarters of 1984 and the first quarter of 1986. No further waste transfers have involved tank 241-AN-103 since the third quarter of 1986. Level changes that have occurred since 1986 are due to water additions and slurry fluctuations caused by gas generation within the waste (*Tank Characterization Report for Double-Shell Tank 241-AN-103*, Field, 1999).

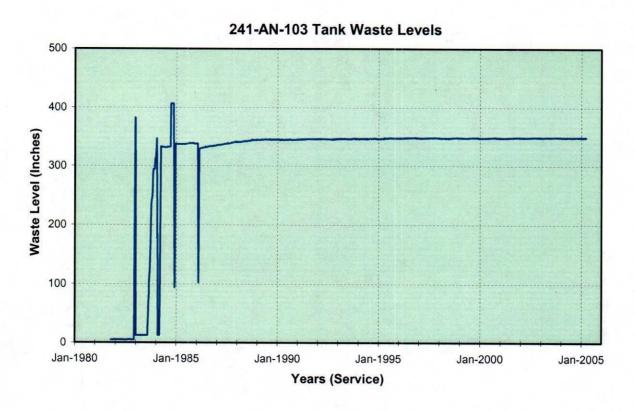
Tank 241-AN-103 currently contains approximately 958,000 gallons of waste equivalent to approximately 348 inches: 499,000 gallons of supernatant (181 inches), and 459,000 gallons of sludge (167 inches). The tank is categorized as sound. (*Waste Tank Summary Report for Month Ending February 28, 2005*, Naiknimbalkar 2005).

The waste level history since October 1981 is shown in Figure 7-1, based on data obtained from the Tank Waste Information Network System (TWINS)¹.

7-1

¹ TWINS, http://twins.pnl.gov/twins.htm, queried 4/27/05 [Data Source: Measurements, SACS, Surface Level, Tank Name AN-103, All Measurement Date values]

Figure 7-1. Waste Level History of Double-Shell Tank 241-AN-103



Since 1983, the minimum recorded waste level was approximately 12.3 inches (January 1983), and the maximum recorded waste level was approximately 406 inches (October and November 1984). During the nineteen year period between February 1986 and April 2005, the waste level remained relatively constant, averaging 347 inches. Since 1990, the average waste level has been 348 inches, its current level.

Since 1990, recorded temperatures of the tank have ranged from a maximum of 119°F (January 1994) to a minimum of 62°F (February 2001), and have averaged 94°F. Since 2002, Tank temperatures have averaged 91°F. This is based on data obtained from the TWINS².

² TWINS, http://twins.pnl.gov/twins.htm, queried 4/27/05 [Data Source: Measurements, SACS, Tank Temperature Readings, Tank Name AN-103, All Measurement Date values].

8.0 GENERAL REQUIREMENTS AND INSPECTION SCOPE

FY 2005 Contract Number 21186, Release 13, specifies that the contractor provide (among others) the following deliverables to the Double-Shell Tank Integrity Project (DSTIP) organization:

- The contractor shall provide AN-103 NDE Support and Data Analysis
- The contractor shall prepare recommended engineering reports and studies as directed by the DSTIP project leads

The areas on the primary tank that were identified for UT inspection in the engineering task plan (Jensen 2005) and work package number WFO-04-0147 are described below.

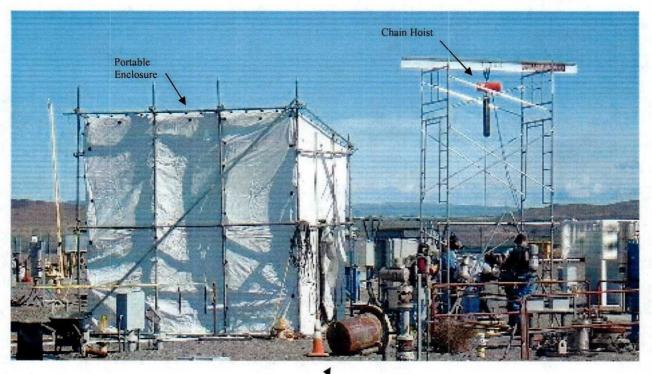
Primary Tank Wall and Welds:

- A vertical strip (approximately 30 inches wide by 35 feet long) of the primary tank wall between the upper haunch transition and the lower knuckle for pits, cracks, and wall thinning. The vertical strip may be comprised of one or more strips whose total width is 30 inches.
- A horizontal strip (15 inches wide by 20 feet long) centered on the average elevation of the liquid-air interface that existed for five years or longer.
- Twenty feet of the circumferential weld joining the cylinder to the lower knuckle, one vertical weld joining the lowest shell course plates (about 10 feet of weld), and one vertical weld joining the next to the lowest shell course plates (about 10 feet of weld). A minimum of twenty (20) feet of vertical weld shall be examined.

9.0 EQUIPMENT SETUP AT AN TANK FARM

Prior to performing the actual inspection, the shield plug was removed from the 24 inch Riser 025, and a temporary cover and riser extension were secured to the riser. A portable enclosure was installed near the riser to provide the means for deploying the UT equipment and protecting the operators from the weather. An electric chain hoist, mounted to scaffolding adjacent to the portable enclosure, was used for maneuvering the equipment into position. The control center trailer was set up outside the AN Tank Farm's boundary fence, and the control cables were run along the ground to the equipment located at the riser. The tank farm setup is shown in Figure 9-1.

Figure 9-1. UT Equipment Installation at DST AN-103 4/4/05



Shield Plug

10.0 INSPECTION RESULTS

Tank 241-AN-103 was fabricated from carbon steel plate. The primary tank's exterior surface varies from mill scale to coatings of various degrees of rust caused by in-service corrosion of carbon steel. A description of the plates is as follows with the location of the plates as shown in Figure 10-1 (*Tank Cross Section 241-AN Tanks*, Vitro Hanford 1979).

Primary Tank Upper Knuckle – Connects dome of tank to side-wall

Primary Tank Wall – Consists of (from top to bottom)

Plate #1 – approximately 7 feet 8 inch tall, 1/2 inch nominal thickness

Plate #2 – approximately 7 feet 8 inch tall, 1/2 inch nominal thickness

Plate #3 – approximately 7 feet 8 inch tall, 1/2 inch nominal thickness

Plate #4 – approximately 9 feet tall, 3/4 inch nominal thickness

Plate #5 – approximately 2 feet tall, 7/8 inch nominal thickness

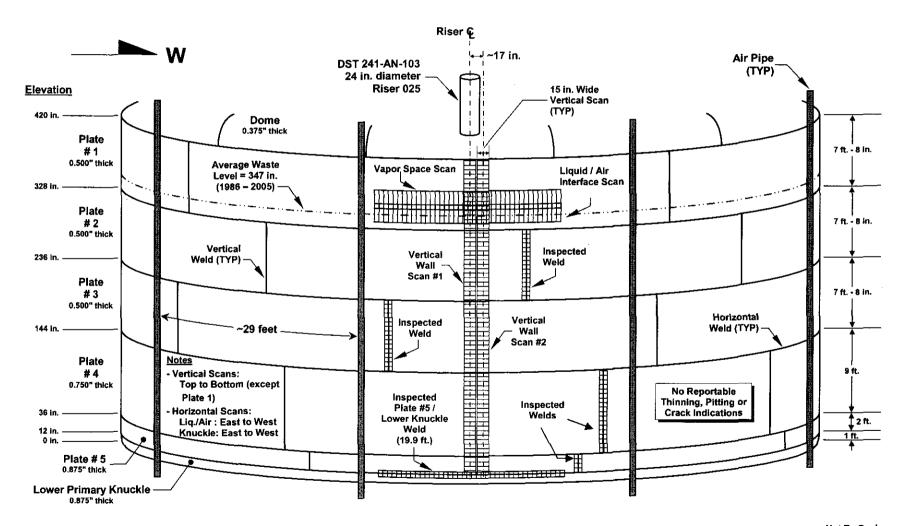
Primary Tank Lower Knuckle – Approximately 7/8 inch nominal thickness. Connects sidewall of tank to primary tank bottom.

Primary Tank Bottom – Connected to primary tank lower knuckle. The outer three feet is approximately 7/8 inch nominal thickness, transitioning to 1/2 inch nominal thickness.

The P-scan crawler was deployed through the 24 inch diameter annulus inspection Riser 025 at the north side of tank 241-AN-103 for examinations of the primary tank wall, vertical and horizontal welds. All tank welds examined were in the "as-welded" condition. The various scan paths for the crawlers are shown in Figure 10-1, along with other pertinent tank information.

The UT P-scan data were examined by COGEMA Engineering's Level III certified inspector and by Limited Level II certified inspectors. The Limited Level II inspectors were "P-scan Limited", indicating that they are qualified to collect and examine the P-scan data, but are not qualified to interpret the data.

Figure 10-1. Schematic of UT Scan Paths on North Side of Tank 241-AN-103 Wall (via Riser 025)



The following pages contain tables that present summary and detailed wall thickness data, which were derived from the COGEMA "Automated Ultrasonic Thickness Data Report Sheets". The inspection data sheets, the transducer calibration sheets, the original tank wall and weld scan map, and an interpretation of the data by an independent Level III certified NDE Inspector are included in Attachment 2 for the P-scan data.

Tables 10-1 through 10-4 summarize the minimum wall thickness values obtained using the P-scan system on the primary tank walls, which includes the liquid-air interface, and the vapor space above the interface.

Tables 10-5 and 10-6 summarize the minimum wall thickness values obtained using the P-scan system on the primary tank vertical welds and the primary tank lower knuckle weld.

Although the data are reported to three significant figures, the accuracy of the wall thickness data, based on the results of the performance demonstration test, is 0.012 inch root-mean-square (RMS).

Table 10-1. Summary of Primary Tank Wall Scan 1 (via Riser 025)

Plate Description	Elevation of Wall Scan (inches)	Wall Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Plate #1	419.4 to 329	90.4	0.500	0.486	97.2%
Plate #2	327 to 237.7	89.3	0.500	0.496	99.2%
Plate #3	235 to 145.6	89.4	0.500	0.489	97.8%
Plate #4	143 to 38.4	104.6	0.750	0.726	96.8%
Plate #5	35 to 13.8	21.2	0.875	0.846	96.7%

⁽¹⁾ All scan widths were 15 inches.

Table 10-2. Summary of Primary Tank Wall Scan 2 (via Riser 025)

Plate Description	Elevation of Wall Scan (inches)	Wall Scan Distance (inches) ⁽¹⁾	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Plate #1	419.6 to 329	90.6	0.500	0.505	101.0%
Plate #2	327 to 237.7	89.3	0.500	0.502	100.4%
Plate #3	235 to 146.4	88.6	0.500	0.470	94.0%
Plate #4	143 to 38.4	104.6	0.750	0.721	96.1%
Plate #5	35 to 14.3	20.7	0.875	0.849	97.0%

⁽¹⁾ All scan widths were 15 inches.

Table 10-3. Summary of Primary Tank Liquid-Air Interface Wall Scan (via Riser 025)

Plate Description	Elevation of Horizontal Wall Scan (inches)	Wall Scan Distance (inches) ⁽¹⁾	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Liquid-Air Interface Plate #1	335 to 355	240.0	0.500	0.470	94.0%

⁽¹⁾ Scan width was 17 inches.

Table 10-4. Summary of Primary Tank Vapor Space Above The Liquid-Air Interface Wall Scan (via Riser 025)

Plate Description	Elevation of Horizontal Wall Scan (inches)	Wall Scan Distance (inches) ⁽¹⁾	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Liquid-Air Interface Plate #1	335 to 355	240.0	0.500	0.476	95.2%

⁽¹⁾ Scan width was 15 to 17 inches.

Table 10-5. Summary of Primary Tank Weld Scans (via Riser 025)

Weld Description	Elevation of Weld Scan (inches)	Weld Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Vertical Weld Plate #2	327 to 238.2	88.8	0.500	0.464	92.8%
Vertical Weld Plate #3	235 to 146.1	88.9	0.500	0.455	91.0%
Vertical Weld Plate #4	143 to 40.2	102.8	0.750	0.708	94.4%
Vertical Weld Plate #5	35 to 13.8	21.2	0.875	0.848	96.9%

⁽¹⁾ Scan widths were 11.4 – 11.9 inches.

Table 10-6. Summary of Plate #5 / Knuckle Horizontal Weld Scans (via Riser 025)

Weld Description	Vertical Location of Weld Scan	Weld Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Horizontal Weld Plate #5 to Knuckle, Plate #5 Side	From ~1 in. to ~5.5 in. above Plate #5 / Knuckle Weld	239.3	0.875	0.8292	94.7%
Horizontal Weld Plate #5 to Knuckle, Knuckle Side	From ~1 in. to ~5.5 in. below Plate #5 / Knuckle Weld	239.3	0.875	0.886	101.3%

⁽¹⁾ Scan widths were 9.7 – 10.85 inches

Tables 10-7 through 10-16 contain the detailed data for the primary tank vertical wall scans as presented in 12 inch long by 15 inch wide connecting scans. Table 10-17 contains the detailed data for the Plate #1 liquid-air interface scan as presented in 12 inch long by 17 inch wide connecting scans.

Table 10-7. Primary Tank Vertical Wall Scan 1 – Plate #1 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	329	0 – 12 (1)	0.500	0.534	0.512
	341	12 – 24	0.500	0.537	0.510
C 403 / 337 31 /	353	24 – 36	0.500	0.539	0.519
Scan "Vert. Wall / Plate 1"	365	36 – 48	0.500	0.539	0.513
(Page Att. 2-3)	377	48 – 60	0.500	0.539	0.512
	389	60 – 72	0.500	0.540	0.486
	401	72 – 84	0.500	0.536	0.510
	413	84 – 90.4	0.500	0.531	0.509

⁽¹⁾ Scan start was 1 inch above the centerline of the second horizontal weld (scanned from bottom of plate to top of plate), and centerline of 24 inch Riser 025; Scan width was 15 inches.

Table 10-8. Primary Tank Vertical Wall Scan 1 - Plate #2 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	327	0 – 12 (1)	0.500	0.519	0.496
	315	12 – 24	0.500	0.521	0.501
Scan	303	24 – 36	0.500	0.522	0.501
"Vert. Wall /	291	36 – 48	0.500	0.522	0.500
Plate 2"	279	48 – 60	0.500	0.522	0.497
(Page Att. 2-4)	267	60 – 72	0.500	0.522	0.500
	255	72 – 84	0.500	0.521	0.499
	243	84 – 89.3	0.500	0.521	0.499

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld, and centerline of 24 inch Riser 025; Scan width was 15 inches.

Table 10-9. Primary Tank Vertical Wall Scan 1 - Plate #3 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.500	0.519	0.498
	223	12 – 24	0.500	0.521	0.496
Scan	211	24 – 36	0.500	0.522	0.498
"Vert. Wall /	199	36 – 48	0.500	0.523	0.501
Plate 3"	187	48 – 60	0.500	0.523	0.499
(Page Att. 2-5)	175	60 - 72	0.500	0.521	0.495
	163	72 – 84	0.500	0.519	0.494
	151	84 – 89.4	0.500	0.517	0.489

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld, and centerline of 24 inch Riser 025; Scan width was 15 inches.

Table 10-10. Primary Tank Vertical Wall Scan 1 – Plate #4 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	143	0 – 12 (1)	0.750	0.756	0.729
	131	12 - 24	0.750	0.755	0.733
	119	24 – 36	0.750	0.754	0.735
Scan "Vert. Wall /	107	36 – 48	0.750	0.754	0.735
Plate 4"	95	48 – 60	0.750	0.754	0.733
(Page Att. 2-6)	83	60 – 72	0.750	0.754	0.735
	71	72 – 84	0.750	0.752	0.728
	59	84 – 96	0.750	0.753	0.726
	47	96 – 104.6	0.750	0.752	0.731

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld, and centerline of 24 inch Riser 025; Scan width was 15 inches.

Table 10-11. Primary Tank Vertical Wall Scan 1 - Plate #5 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Wall / Plate 5"	35	0 – 12 (1)	0.875	0.883	0.850
(Page Att. 2-7)	23	12 – 21.2	0.875	0.884	0.846

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld, and centerline of 24 inch Riser 025; Scan width was 15 inches.

Table 10-12. Primary Tank Vertical Wall Scan 2 - Plate #1 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	329	0 – 12 (1)	0.500	0.539	0.524
	341	12 – 24	0.500	0.541	0.524
	353	24 – 36	0.500	0.543	0.522
Scan "Vert. Wall / 2 nd / Plate 1"	365	36 – 48	0.500	0.543	0.519
(Page Att. 2-13)	377	48 – 60	0.500	0.542	0.505
(rage Att. 2-13)	389	60 – 72	0.500	0.541	0.515
	401	72 – 84	0.500	0.539	0.517
	413	84 –90.6	0.500	0.541	0.519

⁽¹⁾ Scan start was 1 inch above the centerline of the second horizontal weld (scanned from bottom of plate to top of plate), and 17 inches west of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-13. Primary Tank Vertical Wall Scan 2 - Plate #2 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	327	0 – 12 (1)	0.500	0.523	0.502
	315	12 – 24	0.500	0.527	0.507
C 437 337-11/	303	24 – 36	0.500	0.525	0.511
Scan "Vert. Wall / 2 nd / Plate 2"	291	36 – 48	0.500	0.525	0.503
(Page Att. 2-14)	279	48 – 60	0.500	0.525	0.509
	267	60 – 72	0.500	0.525	0.509
	255	72 – 84	0.500	0.525	0.505
	243	84 – 89.3	0.500	0.525	0.511

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld, and 17 inches west of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-14. Primary Tank Vertical Wall Scan 2 - Plate #3 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.500	0.509	0.488
	223	12 – 24	0.500	0.510	0.470
Scan "Vert. Wall /	211	24 – 36	0.500	0.513	0.491
2 nd / Plate 3"	199	36 – 48	0.500	0.514	0.490
(Page Att. 2-15)	187	48 – 60	0.500	0.515	0.493
	175	60 – 72	0.500	0.513	0.490
	163	72 – 84	0.500	0.512	0.485
	151	84 – 88.6	0.500	0.508	0.490

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld, and 17 inches west of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-15. Primary Tank Vertical Wall Scan 2 - Plate #4 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	143	0 – 12 (1)	0.750	0.757	0.728
	131	12 – 24	0.750	0.758	0.733
	119	24 – 36	0.750	0.756	0.732
Scan "Vert. Wall /	107	36-48	0.750	0.757	0.733
2 nd / Plate 4"	95	48 – 60	0.750	0.756	0.721
(Page Att. 2-16)	83	60 – 72	0.750	0.756	0.726
	71	72 – 84	0.750	0.755	0.723
	59	84 – 96	0.750	0.756	0.727
	47	96 – 104.6	0.750	0.756	0.726

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld, and 17 inches west of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-16. Primary Tank Vertical Wall Scan 2 - Plate #5 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Wall / 2 nd / Plate 5"	35	0 – 12 (1)	0.875	0.882	0.849
(Page Att. 2-17)	23	12 – 20.7	0.875	0.885	0.852

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld, and 17 inches west of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-17. Primary Tank Wall Historical Liquid-Air Interface Scan – Plate #1 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Horizontal Wall Scan (inches)	Horizontal Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
		0 – 12 ⁽¹⁾	0.500	0.552	0.526
	323	12 – 24	0.500	0.554	0.528
	to 308	24 – 36	0.500	0.552	0.528
Scan	(5 inches to	36 – 48	0.500	0.551	0.521
"Liquid Air	20 inches	48 – 60	0.500	0.552	0.523
Interface /1"	above	60 – 72	0.500	0.550	0.520
(Page Att 2-23)	Plate #1 / Plate #2 Horizontal Weld)	72 – 84	0.500	0.548	0.524
		84 – 96	0.500	0.548	0.517
		96 – 108	0.500	0.548	0.521
		108 – 120	0.500	0.548	0.518
	:	0 – 12 (2)	0.500	0.549	0.516
	323	12 – 24	0.500	0.549	0.524
	to 308	24 – 36	0.500	0.549	0.523
Scan	(5 inches to	36 – 48	0.500	0.549	0.510
"Liquid Air	20 inches	48 – 60	0.500	0.549	0.523
Interface / A"	above	60 – 72	0.500	0.548	0.470
(Page Att 2-24)	Plate #1 / Plate #2	72 – 84	0.500	0.547	0.519
	Horizontal	84 – 96	0.500	0.548	0.518
	Weld)	96 – 108	0.500	0.541	0.515
		108 – 120	0.500	0.541	0.516

⁽¹⁾ Start of scan east of 24 inch Riser 025; Scan width was 17 inches.

⁽²⁾ Start of scan @ end of scan Liquid Air Interface; Scan width was 17 inches.

Table 10-18. Primary Tank Wall Vapor Space Above The Historical Liquid-Air Interface Scan - Plate #1 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Horizontal Wall Scan (inches)	Horizontal Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
		0 – 12 (1)	0.500	0.543	0.505
	323	12 – 24	0.500	0.543	0.518
	to 308	24 – 36	0.500	0.545	0.519
Scan	(5 inches to	36 – 48	0.500	0.543	0.519
"Liquid Air"	20 inches	48 – 60	0.500	0.542	0.514
(Vapor Space)	above	60 – 72	0.500	0.543	0.476
(Page Att 2-25)	Plate #1 / Plate #2 Horizontal	72 – 84	0.500	0.541	0.485
		84 – 96	0.500	0.539	0.511
	Weld)	96 – 108	0.500	0.538	0.509
		108 – 120	0.500	0.538	0.508
		0 – 12 (2)	0.500	0.538	0.505
	323	12 – 24	0.500	0.538	0.508
	to 308	24 - 36	0.500	0.538	0.514
Scan	(5 inches to	36 – 48	0.500	0.540	0.511
"Liquid Air / A"	20 inches	48 – 60	0.500	0.539	0.505
(Vapor Space)	above	60 - 72	0.500	0.539	0.509
(Page Att 2-26)	Plate #1 / Plate #2	72 – 84	0.500	0.538	0.508
	Horizontal Weld)	84 – 96	0.500	0.537	0.508
		96 – 108	0.500	0.537	0.508
		108 – 120	0.500	0.532	0.506

⁽¹⁾ Start of scan east of 24 inch Riser 025 @ east air line; Scan width was 15 to 17 inches.
(2) Start of scan @ end of scan Liquid Air Interface; Scan width was 17 inches.

Table 10-19. Primary Tank Vertical Wall Weld Scan - Plate #2 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	327	0 – 12 (1)	0.500	0.510	0.486
	315	12 – 24	0.500	0.514	0.498
Scan	303	24 – 36	0.500	0.515	0.491
"Vert. Weld/	291	36 – 48	0.500	0.517	0.491
Plate 2"	279	48 – 60	0.500	0.515	0.485
(Page Att. 2-27)	267	60 – 72	0.500	0.516	0.500
	255	72 – 84	0.500	0.516	0.499
	243	84 – 88.8	0.500	0.517	0.464

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld; Scan width was 11.8 inches.

Table 10-20. Primary Tank Vertical Wall Weld Scan - Plate #3 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.500	0.505	0.476
	223	12 – 24	0.500	0.509	0.474
Scan	211	24 – 36	0.500	0.505	0.462
"Vert. Weld/	199	36 – 48	0.500	0.510	0.470
Plate 3"	187	48 – 60	0.500	0.500	0.455
(Page Att. 2-28)	175	60 – 72	0.500	0.501	0.458
	163	72 – 84	0.500	0.502	0.459
	151	84 – 88.9	0.500	0.505	0.460

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld; Scan width was 11.9 inches.

Table 10-21. Primary Tank Vertical Wall Weld Scan - Plate #4 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	143	0 – 12 (1)	0.750	0.756	0.708
	131	12 – 24	0.750	0.752	0.733
	119	24 – 36	0.750	0.752	0.731
Scan "Vert. Weld/	107	36 – 48	0.750	0.750	0.718
Plate 4"	95	48 – 60	0.750	0.753	0.731
(Page Att. 2-29)	83	60 – 72	0.750	0.752	0.727
	71	72 – 84	0.750	0.752	0.730
	59	84 – 96	0.750	0.755	0.719
	47	96 – 102.8	0.750	0.756	0.738

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld; Scan width was 11.5 inches.

Table 10-22. Primary Tank Vertical Wall Weld Scan - Plate #5 (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Weld/	35	0 – 12 (1)	0.875	0.875	0.848
Plate 5" (Page Att. 2-30)	23	12 – 21.2	0.875	0.875	0.850

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld; Scan width was 11.4 inches.

Table 10-23. Primary Tank Horizontal Weld - Plate #5 to Knuckle Scan, Plate #5 Side (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Horizontal Weld Scan (inches)	Horizontal Location of Weld Scan, Plate #5 Side (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
		0 – 12 ^(l)	0.875	0.893	0.842
		12 – 24	0.875	0.890	0.870
		24 – 36	0.875	0.886	0.858
Scan	From ~1 in, to	36 – 48	0.875	0.887	0.856
"Horz. Weld /	~5.4 in. above	48 – 60	0.875	0.887	0.857
Plate / Knuckle"	Plate #5 / Knuckle Weld	60 – 72	0.875	0.884	0.832
(Page Att. 2-39)		72 – 84	0.875	0.886	0.861
		84 – 96	0.875	0.883	0.849
		96 – 108	0.875	0.881	0.859
		108 - 120	0.875	0.881	0.859
Scan	From ~1 in, to	0 – 12 (2)	0.875	0.885	0.863
"Horz. Weld / Plate / Knuckie	~5.4 in. above	12 – 24	0.875	0.883	0.858
A"	Plate #5 /	24 – 36	0.875	0.883	0.851
(Page Att. 2-40)	Knuckle Weld	36 – 47.8	0.875	0.884	0.842
		0 – 12 (3)	0.875	0.870	0.851
Scan	From ~1 in. to	12 – 24	0.875	0.868	0.843
"Horz. Weld / Plate / Knuckle B"	~5.4 in. above	24 – 36	0.875	0.866	0.829
	Plate #5 /	36 – 48	0.875	0.869	0.850
(Page Att. 2-41)	Knuckle Weld	48 – 60	0.875	0.867	0.849
		60 – 71.5	0.875	0.869	0.848

⁽¹⁾ Start of scan @ east air line, east of 24 inch riser; Scan width was 10.85 inches.

⁽²⁾ Start of scan @ end of previous scan, Horiz. Weld / Plate / Knuckle; Scan width was 10.8 inches.

⁽³⁾ Start of scan @ west of weld attachment, west of 24 inch riser; Scan width was 9.7 inches

Table 10-24. Primary Tank Horizontal Weld - Plate #5 to Knuckle Scan, Knuckle Side (via Riser 025)

Scan I.D. Number (Data Sheets)	Elevation of Horizontal Weld Scan (inches)	Horizontal Location of Weld Scan, Plate #5 Side (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
		0 – 12 (1)	0.875	0.939	0.912
		12 – 24	0.875	0.936	0.901
		24 – 36	0.875	0.940	0.920
Scan	From ~1 in. to	36 – 48	0.875	0.940	0.920
"Horiz. Weld /	~5.4 in. below	48 – 60	0.875	0.939	0.906
Plate / Knuckle"	Plate #5 / Knuckle Weld	60 – 72	0.875	0.940	0.924
(Page Att. 2-42)	Knuckie weid	72 – 84	0.875	0.937	0.914
		84 – 96	0.875	0.939	0.914
		96 – 108	0.875	0.930	0.894
		108 – 120	0.875	0.935	0.912
Scan	From ~1 in. to	0 – 12 (2)	0.875	0.939	0.913
"Horiz. Weld / Plate / Knuckle	~5.4 in. below	12 – 24	0.875	0.931	0.896
A"	Plate #5 /	24 – 36	0.875	0.931	0.914
(Page Att. 2-43)	Knuckle Weld	36 – 47.8	0.875	0.931	0.916
		0 – 12 (3)	0.875	0.915	0.886
Scan	From ~1 in. to	12 – 24	0.875	0.937	0.895
"Horiz. Weld / Plate / Knuckle	~5.4 in. below	24 – 36	0.875	0.931	0.901
B"	Plate #5 /	36-48	0.875	0.931	0.892
(Page Att. 2-44)	Knuckle Weld	48 – 60	0.875	0.931	0.910
		60 – 71.5	0.875	0.931	0.902

⁽¹⁾ Start of scan @ east air line, east of 24 inch riser; Scan width was 10.8 inches.

⁽²⁾ Start of scan @ end of previous scan, Horiz. Weld / Plate / Knuckle; Scan width was 10.8 inches.

⁽³⁾ Start of scan @ west of weld attachment, west of 24 inch riser; Scan width was 9.7 inches

11.0 EVALUATION OF INSPECTION RESULTS

The results from the inspection of tank 241-AN-103 are evaluated and compared with results of all other tank ultrasonic inspections.

11.1 TANK 241-AN-103 UT DATA EVALUATION

The UT P-scan data were interpreted by J.B. Elder an independent Level III certified NDE inspector. The P-scan data were also examined by W.H. Nelson, COGEMA Engineering's Level III certified inspector. Mr. Nelson independently evaluated the P-scan raw data and concurred with Mr. Elder's interpretation (Attachment 2). The P-scan data have also been evaluated by PNNL as a third party review. Their results and conclusions were found to be consistent with those described in this report. Their P-scan data review is *Ultrasonic Examination of Double-Shell Tank 241-AN-103 - Examination Completed June 2005*, PNNL report number PNNL-15280, Rev. 0 (Attachment 3).

The results of the tank 241-AN-103 UT inspections indicated no reportable wall thinning, no pit-like indications, and no cracking in any of the areas examined. Figure 11-1 illustrates all of the "as-found" average wall thickness measurements of the primary tank vertical wall scans generated from the P-scan Inspection Data Sheets (Attachment 2). Each measurement plotted on Figure 11-1 is the average of all data collected over a 12 inch long by 15 inch wide scan area. Areas of interest for tank 241-AN-103 are the vapor space above the liquid waste, the historical liquid-vapor interface (approximately 28.9 feet or 347 inches), and the liquid region.

The overall average wall thickness measurements for the walls and weld HAZs are tabulated in Table 11-1. The UT data show that the primary tank average wall thickness values exceed the nominal values specified in the design documents. The UT data, when compared to construction specifications, drawings, standards, and codes (241-AN Double-Shell Tanks Integrity Assessment Report, Jensen 1999), reveal that the as-found condition of the tank plates and welds are all within the allowable design limits. A summary of the results associated with the areas examined is presented below.

Primary Tank Wall: Two parallel strips, each ~35 foot long and 15 inches wide, encompassing Plate #1 through Plate #5 were examined. The average ((scan 1 + scan 2)/2) plate wall thicknesses ranged from 100.7% of nominal (plate #4), to 107.8% of nominal (plate #1). The overall average plate wall thickness (of the 5 plates) was 103.5% of nominal. The average ((scan 1 + scan 2)/2) minimum wall thickness values detected ranged from 97.1% of nominal (Plate #5) to 102.7% of nominal (Plate #1). The overall average minimum plate wall thickness was 99.2% of nominal. Of the 12 inch long vertical wall plate scans yielding minimums falling below the nominal values, the greatest thickness deviation was 6.0% below the nominal (Plate #3, Scan 2). No reportable wall thinning, pitting indications or crack-like indications were found.

Figure 11-1. Scan Data Average Wall Thickness Compared to Nominal Plate Thickness

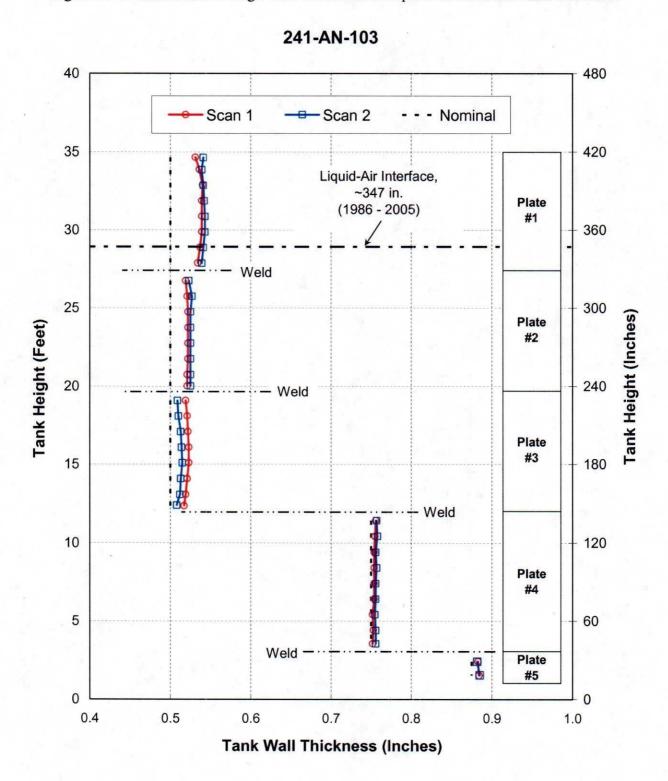


Table 11-1. Average Tank Wall Thickness Values

Scan Description	Scan Location	Scan 1 Average (inches)	Scan 2 Average (inches)	Average Thickness (inches)	Nominal Thickness (inches)	Average minus Nominal (inches)
	Plate #1	0.5369	0.5411	0.5390	0.500	+ 0.039
Vertical	Plate #2	0.5213	0.5250	0.5231	0.500	+ 0.023
Wall	Plate #3	0.5206	0.5118	0.5162	0.500	+ 0.016
Scans ⁽¹⁾	Plate #4	0.7538	0.7563	0.7551	0.750	+ 0.005
	Plate #5	0.8835	0.8835	0.8835	0.875	+ 0.008
Liquid / Air Interface	Plate #1 0.5487		n/a ⁽²⁾	0.5487	0.500	+ 0.049
Vapor Space Above Liquid/Air Interface	Plate #1	0.5396	n/a	0.5396	0.500	+ 0.040
	Plate #2	0.5150	n/a	0.5150	0.500	+ 0.015
Vertical	Plate #3	0.5046	n/a	0.5046	0.500	+ 0.005
Welds	Plate #4	0.7531	n/a	0.7531	0.750	+ 0.003
	Plate #5	0.8750	n/a	0.8750	0.875	0.000
Primary Lower Knuckle Weld	Plate #5 Side	0.8801	n/a	0.8801	0.875	+ 0.005
	Knuckle Side	0.9342	n/a	0.9342	0.875	+ 0.059

⁽¹⁾ Scan 1 and Scan 2 were on the same plate, unless otherwise noted.

Note: The average vertical wall thickness values as shown in figure 11-1, and as shown in table 11-1, reveal a difference of 0.009 inches between scan 1 and scan 2 for plate #3. The precision of these measurements was influenced by significant surface roughness encountered on plate #3.

Since surface roughness contributes to the acoustic properties of the material being tested, a non-uniform surface can cause "chattering" as the transducer travels over rough surfaces. Transducer chattering can cause variations in the thickness of the couplant layer beneath the transducers. And since the couplant layer is a component of the wall thickness measurement (which is compensated for during calibration), a uniform couplant thickness is necessary for maximum accuracy. Also, transducer wear, and calibration variables attributed to the use of different operators, affect measurement repeatability.

⁽²⁾ n/a – not applicable (only one scan performed)

Therefore, couplant thickness variations, transducer wear, and operator variables all contribute to the precision of the wall thickness measurements.

Primary Tank Wall Historical Liquid-Air Interface: A horizontal strip (20 feet long by 17 inches wide) encompassing the Plate #1 historical liquid-air interface (347 inch level) was examined. The average wall thickness detected during the liquid-air scan was 109.7% of nominal, in good agreement with the 107.8% reported above for the plate #1 vertical wall scan. The average minimum plate thickness value detected was 103.6% of nominal, in good agreement with the 102.7% reported above for the plate #1 vertical wall scan. Of the 12 inch long horizontal interface scans yielding minimums falling below the nominal (0.500 inches), the greatest deviation was 6.0% below nominal. No reportable thinning, pitting indications, or crack-like indications were found.

Primary Tank Vapor Space: A horizontal strip (20 feet long by 15-17 inches wide) above the historical liquid-air interface was examined. The average wall thickness detected during the vapor space scan was 107.9% of nominal, also in good agreement with the 107.8% reported above for the plate #1 vertical wall scan. The average minimum plate thickness value detected was 101.5% of nominal, in good agreement with the 102.7% reported above for the plate #1 vertical wall scan. Of the 12 inch long horizontal vapor space scans yielding minimums falling below the nominal (0.500 inches), the greatest deviation was 4.8% below the nominal. No reportable thinning, pitting indications or crack-like indications were found.

Primary Tank Vertical Welds: One vertical weld in each of the four plates #2 through #5 was examined. The average thicknesses of the plate walls adjacent to the welds ranged from equivalent to the nominal plate thickness (plate #5 HAZ), to 103.0% of nominal (plate #2 HAZ). The overall average thickness of the four vertical weld HAZs was 101.1% of the nominal plate thickness values. The average minimum thickness of the plate walls adjacent to the welds ranged from 92.9% of nominal (Plate #3 HAZ) to 97.9% of nominal (Plate #2 HAZ). The overall average minimum thickness of the four vertical weld HAZs was 96.2% of nominal. Of the 12 inch long vertical weld scans yielding minimums falling below the nominal, the greatest deviation was 9.0% below nominal (Plate #3 HAZ). No crack-like indications were found. There were also no reportable wall thinning or pitting indications found.

Primary Tank Knuckle-to-Shell Weld: A 19.9 foot long region of the horizontal knuckle-to-shell weld was examined. No crack-like indications were found. There were also no reportable wall thinning or pitting indications found. The average thickness of the horizontal knuckle-to-plate#5 weld HAZ ranged from 100.6% of nominal (plate-side scan), to 106.8% of nominal (Knuckle-side scan). The overall average thickness of the horizontal weld HAZ was 103.7% of nominal. The average minimum thickness of the horizontal weld HAZ ranged from 97.3% of nominal for the plate-side scan, to 103.7% of nominal for the knuckle-side scan. The overall average minimum thickness of the horizontal weld HAZ was 100.5% of nominal. Of the 12 inch long horizontal weld scans yielding minimums falling below the nominal, the greatest deviation was 5.3% below nominal (plate-side scan).

11.2 DST ULTRASONIC INSPECTION DATA RESULTS COMPARISON

The following Tables 11-2 and 11-3 provide a summary of primary tank vertical wall inspection results and a comparison of primary tank wall thinning.

Table 11-2 reports the inspection results chronologically according to fiscal year (October 1 through September 30).

Table 11-2. Double-Shell Tanks Chronological Inspection Results Findings

Tank	Inspection Year (FY)	Reportable Plate Crack Indication	Reportable Plate Pitting	Reportable Plate Thinning	Reportable Weld Thinning, Pitting or Cracking
AW-103	1997	None	None	None	None
AN-107	1998	None	None	None	None
AN-106	1999	None	None	None	None
AN-105	1999	None	None	Two very minute areas of a plate (20% maximum reduction in thickness) (a)	None
AZ-101	1999	None	None One area of a plate (11.4% maximum reduction in thickness)		None
AY-102	1999	None	None	None	None
AP-107	2000	None	None	None	None
AP-108	2000	None	None	None Two minute areas of a plate (13.8% maximum reduction in thickness).	
AW-101	2001	None	None A pit like indication in a very minute area of a plate (16% maximum reduction in thickness).		None
AW-105	2001	None	None	None None	
AY-101	2001	None	Pit-like indication at historical liquid-air interface	Some pit-like indications identified as thinning	Three areas of 10% wall thinning in vertical welds
AN-102	2001	None	None One minute area of a p (11% maximum reduction thickness)		None
AN-101	2002	None	None	One small area of a plate (12 % maximum reduction in thickness)	Four local areas near vertical welds (14% maximum reduction in thickness)

(Cont. on next page)

Table 11-2. (Cont.) Double-Shell Tanks Chronological Inspection Results Findings

Tank	Inspection Year (FY)	Reportable Plate Crack Indication	Reportable Plate Pitting	Reportable Plate Thinning	Reportable Weld Thinning, Pitting or Cracking	
AW-106	2002	None	None	One small area	10.4% maximum reduction in thickness	
AY-101	2002	Not Investigated	None 72 areas of >10% wall thinning, most in the historical liquid-air interface in Plate #2 (20.2% maximum reduction in thickness)		Not Investigated	
AW-104	2002	None	None	None	None	
AW-102	2002 & 2003 ^(c)	None	None	None	None	
AN-105	2002	None	None	None	Not Investigated	
AP-101	2003	None	None	None	None	
AP-105	2003	None	None	None None		
AP-103	2003	None	None None		None (d)	
AZ-102	2003	None	None	Six small areas in the vicinity of the liquid-air interface in Plate #2 (13.2% to 17.8% maximum reduction in thickness)	Three small areas of wall thinning near the Plate #1 vertical weld (10.9% to 16.8% maximum reduction in thickness)	
SY-103	2004	None	None	Six small areas in the Plate #1 Vapor Space (10.4% to 12.8% maximum reduction in thickness)		
SY-101	2004	None	None	Numerous areas in the vicinity of the historical liquid-air interface on Plate #1 (10.4% to 18.4% maximum reduction in thickness) Numerous areas in the Plate #1 and areas in Plate (10.6% to 17 maximum red in thickness)		
SY-102	2004	None	Plate #1 (10.1% to 12.5%		One small area in Plate #1 (10.7% maximum reduction in thickness)	

(Cont. on next page)

Tank	Tank Inspection Reportable Reportable Plate Plate Crack Pitting Plate Pitting Plate Pitting Plate Plate		Reportable Plate Thinning	Reportable Weld Thinning, Pitting or Cracking	
AP-104	2004	None	None	None	None
AP-106	2005	None	None	None	None
AP-104	2005 ^(e)	Not Investigated	None	None	Not Investigated
AP-102	2005	None	None	Two areas of plate #2 (14% maximum reduction in Thickness).	Five areas of thinning in the HAZ of plate #4 (13% maximum reduction in thickness).
AN-103	2005	None	None	None	None

Table 11-2. (Cont.) Double-Shell Tanks Chronological Inspection Results Findings

The inspection results in Table 11-2 show that the overall condition of the inspected tanks is satisfactory. Wall thickness data gathered from ultrasonic examination of twenty-seven DSTs were compared to evaluate the degree of wall thinning that may have occurred among the tanks examined. These wall thickness data do not allow a direct calculation of wall thinning, since no measurements were made of original plate thicknesses at the time of construction. However, wall thickness data from ultrasonic testing may be compared to the specified nominal plate thickness.

Table 11-3 provides a summary of wall thinning, defined as nominal plate thickness minus average minimum plate thickness³, by nominal plate size, and by DST examined. The data used the minimum wall thickness in each scanning area (generally 12 inches by 15 inches) from the vertical wall scans and then calculated the average for each plate using the minimum thickness values. The negative values in the table indicate where the average of all minimum values of plate thickness exceeds nominal plate thickness. The Table also provides the calculated average wall thinning and associated standard deviation by DST examined for all nominal plate thicknesses, and by nominal plate thickness for all DSTs examined.

Tank 241-AN-103 did not exhibit any significant thinning.

⁽a) Based on a review of the tank 241-AN-105 data gathering technique in FY 1999, prompted by the FY 2002 results, the FY 1999 wall thinning data is considered questionable.

⁽b) Although below reporting criteria at the time, one linear crack-like indication 6 inch long by 0.142 inch deep in a nominal 0.750 inch thick plate was observed. Subsequent examination of tank 241-AP-108 in FY 2002 revealed no change in size.

⁽c) Primary knuckle examination using T-SAFT conducted in FY 2003.

⁽d) One linear crack-like indication 2.92 inches long in the weld heat-affected zone of a nominal 0.875 inch thick plate was detected. A follow-up inspection determined that the indication is a small area of incomplete fusion that is not open to either surface of the tank.

⁽e) Primary tank upper knuckle examination only.

Average minimum plate thickness is defined as the average of all the minimum measured thicknesses for each scanning area (generally 12 inches by 15 inches) for a given plate size and DST.

Table 11-3. Tank Wall Thinning By Nominal Plate Size

DST	FY	Wall Thinning* By Nominal Plate Size (Inches)						
	Examined	0.375"	0.500"	0.5625"	0.750"	0.875"	AVG	STD DEV
AN-101	2002	n/a	0.008	n/a	0.027	0.015	0.013	0.014
AN-102	2001	n/a	0.004	n/a	0.003	0.005	0.004	0.016
AN-103	2005	n/a	-0.003	n/a	0.020	0.026	0.005	0.015
AN-105	1999	n/a	0.026	n/a	0.007	0.001	0.019	0.032
AN-105	2002	n/a	0.015	n/a	n/exam.	n/exam.	0.015	0.021
AN-106	1999	n/a	0.006	n/a	0.015	0.012	0.009	0.009
AN-107	1998	n/a	-0.018	n/a	-0.015	0.013	-0.016	0.017
AP-101	2003	n/a	-0.008	-0.003	-0.002	0.010	-0.004	0.008
AP-102	2005	n/a	0.029	0.056	0.040	0.065	0.040	0.024
AP-103	2003	n/a	0.008	-0.004	-0.009	0.007	0.000	0.012
AP-104	2004	n/a	-0.006	-0.016	-0.016	0.011	-0.010	0.014
AP-105	2003	n/a	0.004	-0.006	-0.002	0.010	0.000	0.009
AP-106	2005	n/a	-0.007	0.006	-0.012	0.012	-0.004	0.012
AP-107	2000	n/a	-0.011	-0.012	-0.017	-0.013	-0.013	0.008
AP-108	2000	n/a	-0.017	-0.012	-0.011	-0.005	-0.014	0.016
AW-101	2001	n/a	0.008	n/a	0.014	0.020	0.010	0.013
AW-102	2002	n/a	-0.019	n/a	-0.006	0.008	-0.014	0.012
AW-103	1997	n/a	-0.010	n/a	-0.005	0.004	-0.007	0.008
AW-104	2002	n/a	-0.036	n/a	-0.031	-0.007	-0.033	0.011
AW-105	2001	n/a	0.000	n/a	0.008	-0.003	0.002	0.018
AW-106	2002	n/a	-0.004	n/a	0.015	0.000	0.001	0.016
AY-101	2001	-0.011	0.030	n/a	0.018	0.012	0.030	0.029
AY-102	1999	-0.021	0.001	n/a	0.008	n/a	0.000	0.012
AZ-101	1999	0.021	0.027	n/a	0.020	0.003	0.024	0.011
AZ-102	2003	0.017	0.007	n/a	-0.011	-0.004	0.002	0.019
SY-101	2004	0.056	0.009	n/a	0.026	-0.030	0.015	0.020
SY-102	2004	0.042	0.007	n/a	0.009	0.031	0.012	0.014
SY-103	2004	0.041	0.008	n/a	0.019	-0.022	0.012	0.015
1	AVG:	0.021	0.002	0.001	0.005	0.007	100	ulaşanı ileşi
STD	DEV:	0.028	0.022	0.023	0.020	0.020	4.5	152

^{*} Thinning = nominal plate size - minimum thickness n/a - not applicable; n/exam. - not examined

12.0 FINDINGS, CONCLUSIONS, AND RECOMMENDATIONS

The findings, conclusions, and recommendations from the UT inspection of DST 241-AN-103 are listed below.

Primary Tank Walls

- No reportable wall thinning was detected in any of the areas examined. The primary wall vertical scans yielded overall average ((scan 1 + scan 2)/2) wall thickness values that ranged from 100.7% of nominal (plate# 4), to 107.8% of nominal (plate# 1). The overall average ((scan 1 + scan 2)/2) minimum wall thickness values ranged from 97.1% of nominal (Plate #5) to 102.7% of nominal (Plate #1). Of the 12 inch long vertical wall plate scans yielding minimums falling below the nominal values, the greatest deviation was 6.0% below the nominal (Plate #3, Scan 2).
- Neither reportable pitting indications nor any crack-like indications were detected in any of the vertical wall plates.

Liquid / Air Interface and Vapor Space (Above the Liquid / Air Interface)

- There were no areas of reportable wall thinning, cracking, or pit-like indications detected during the primary tank horizontal wall scan of the historical liquid-air interface, nor were there any areas of reportable wall thinning, cracking, or pit-like indications detected during the primary tank horizontal wall scan of the vapor space above the historical liquid-air interface.
- The overall average horizontal wall scan thickness values detected ranged from 107.9% of nominal (vapor-space scan), to 109.7% of nominal (liquid-air scan). The average minimum horizontal wall thickness values detected ranged were 101.5% of nominal for the vapor space scan, and 103.6% of nominal for the Liquid-Air Interface Scan. Of the 12 inch long horizontal wall plate scans yielding minimums falling below the nominal value (0.500 inches), the greatest deviation was 6.0% below the nominal for the liquid-air scan, and 4.8% below the nominal for the vapor space scan.

Primary Tank Welds

- No crack-like indications were detected in any of the weld HAZ.
- No reportable wall thinning or reportable pitting indications were detected in any of the weld HAZ. The primary tank vertical weld scans (plate #2 through #5) and the knuckle-to-shell horizontal weld scan (plate #5 to lower knuckle) yielded overall average wall thickness values that were 101.1% of nominal for the vertical walls HAZ, and 103.7% of nominal for the horizontal knuckle/plate weld HAZ. The overall average minimum weld HAZ thickness value detected was 96.2% of nominal for the vertical welds HAZ, and 100.5% of nominal for the horizontal weld HAZ. Of the 12 inch long HAZ scans yielding

minimums falling below the nominal values, the greatest deviation was 9.0% below nominal (plate #3) for the vertical welds HAZ, and 5.3% of nominal (plate-side scan) for the horizontal weld HAZ.

Conclusions

• Based on the results of this examination (no reportable indications), the material condition of DST AN-103 is satisfactory for continued operation.

Recommendations

 According to a recent Tank Integrity Assessment Project DST Lifecycle Schedule, tank 241-AN-103 is scheduled for its second, standard UT examination in about eight years. Based on the results of this UT examination, it is recommended that this schedule be maintained – there is no reason to perform any near-term follow-up inspections on this tank. Following the second UT examination, inspection parameters such as wall thinning rates can be calculated and used to better quantify and evaluate any continual wall thinning or degradation.

A visual examination of tank 241-AN-103 is scheduled in FY 2009 that will include visually examining the internal primary tank wall.

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ATTACHMENT 1

AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

(COGEMA Engineering Corporation Procedure COGEMA-SVUT-INS-007.3, Rev. 2 Effective: December 16, 2003)

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AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

1.0 PURPOSE

This procedure establishes the method, equipment, and requirements for automated, direct contact, ultrasonic test (UT) straight-beam, thickness measurements, angle beam flaw detection, and sizing, in carbon steel waste storage tanks utilizing the "P-scan" ultrasonic imaging system.

2.0 SCOPE

2.1 Requirements

The requirements herein are applicable to weld inspection, crack detection, sizing, wall thickness measurement, and the detection of wall thinning conditions, such as pitting, erosion, and corrosion in double shell tanks from 0.100 inches to 1.0 inch in thickness. At least one side must be accessible and the component surface to be measured must be parallel with the opposite surface. The requirements are also applicable to the automated UT detection and depth sizing of surface connected planar flaws.

2.2 Scanning

Scanning is performed using remotely controlled automatic scanners.

2.3 Examinations

Examinations shall be performed from inside the annulus of the double shell tanks.

2.4 Instructions

This procedure provides the instructions for the use of Tip Diffraction Techniques including the Absolute Arrival Time Technique (AATT), and the Relative Arrival Time Technique (RATT), for the sizing of planar flaws.

2.5 Methodology

The methodology in this procedure meets the requirements as addressed in Reference 4.1 as applicable to meet the requirements for inspection of double shell tanks.

3.0 RESPONSIBILITIES

Only certified Level II or Level III ultrasonic examiners shall interpret data to determine whether it represents relevant or non-relevant indication in accordance with the applicable specification. Level III ultrasonic examiners shall review all data collected prior to issuing a final report.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

4.0 REFERENCES

- 4.1 ASME Boiler & Pressure Vessel Code, Section V, Article 4, 1995 Edition.
- 4.2 COGEMA SV-CP-PRC-014, Qualification and Certification OF NDE Personnel.
- 4.3 COGEMA SVAD-PRC-001, Nondestructive Examination Administrative Procedure.
- 4.4 COGEMA SVUT-PRC-007, Ultrasonic Examination Procedure.
- 4.5 FORCE Institutes, P-scan System 4 Instruction Manual

5.0 PERSONNEL REQUIREMENTS

5.1 Personnel Qualifications

Personnel performing or supervising data acquisition or performing data analysis to the requirements of this procedure shall be qualified and certified to at least level II in ultrasonics in accordance with reference 4.2 or equivalent. In addition, they shall be trained in techniques for sizing stress corrosion cracking/planar flaws.

5.2 Certification Level

Personnel performing review for final acceptance of examination data shall be certified to at least level II in ultrasonics in accordance with reference 4.2 or equivalent.

5.3 Support Personnel

Personnel, whose responsibilities are limited to set-up, tear down, and track or scanner operation need not be certified. Such personnel shall possess sufficient knowledge of the equipment to satisfy the Level III examiner.

6.0 EQUIPMENT

6.1 Ultrasonic Instrument/Examination System

The P-scan computerized pulse-echo ultrasonic inspection system shall be used. The system shall be equipped with a stepped gain control in units of 1dB with a dynamic range of at least 115 dB, capable of generating and receiving frequencies in the range of 0.5 to 15 MHz. The following components may be used:



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PS-4	P-scan processor			
Analysis computer	Off-line data analysis with P-scan analysis software			
Digital Controller, WSC-2S, or other approved scan controller	Automatic scanner controller			
AWS-5, AWS5-D, RUTI*	Automatic P-scan scanner			
Pump	Couplant pump for P-scan system			

^{*}Remote Ultrasonic Test Instrument (RUTI) system

6.2 Transducers

Straight-beam and angle-beam transducers with single or dual elements, with or without delay tips, may be used, provided they can be attached to and manipulated by the scanner, and can be adequately coupled to the test item with a resultant backwall signal response of at least a 2 to 1 signal-to-noise ratio. Sizes and frequencies shall be as specified for the following applications:

- 6.2.1 For high sensitivity applications such as the detection of pitting, erosion or corrosion, transducer sizes in the range of 1/4 inch to 1/2 inch, with a frequency in the range of 4.0 to 10 MHz, shall be used.
- 6.2.2 For weld inspection, detection and sizing of planar flaws that are open to the surface, angle beam transducers with a nominal angle of 45°, with an element size in the range of 1/4 inch to 1/2 inch, and with a frequency in the range of 4.0 to 10 MHz, shall be used. Where interference from weld geometry prevents examination of the required volume with a 45° transducer, a 60° angle may be substituted.
- 6.2.3 Transducers of other angles, element sizes, modes of propagation, or frequencies outside the above ranges may be used to suit other required examination techniques.

6.3 Cables

- 6.3.1 Cables of any compatible type and number of connectors may be used for examination. The length shall be limited to 400 feet, or less where signal degradation occurs. The same cables shall be used for calibration and examination.
- 6.3.2 The scanner control cable for analog scanners shall be limited to 330 feet maximum. Digitally controlled scanners shall have a maximum cable length as stipulated by the manufacture's recommendation.



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6.4 Couplant

- 6.4.1 Site approved water should be used as couplant for the examination.
- 6.4.2 Couplant application should be accomplished by means of an automatic couplant delivery system whenever possible. Care should be taken to use only as much water as required, as excess water in the annulus is undesirable.

6.5 User Calibration Blocks

- 6.5.1 For general thickness measurements, or the detection of pitting, erosion, or corrosion, user calibration blocks shall be made of an acoustically similar material as that being measured. A standard step block with 0.1 inch or greater increments encompassing the nominal thickness to be measured shall be used.
- 6.5.2 For weld inspection, crack detection and sizing measurements, user calibration blocks shall be made of an acoustically similar material as that being measured. A standard notched block with 0.1 inch or greater increments encompassing the nominal thickness to be measured shall be used.

6.6 Reference Blocks

Reference blocks (e.g., Rompas, IIW, DSC) utilized for beam angle exit point determination or screen width calibration shall be of similar material composition as the component under examination.

6.7 Pulse Repetition Rate

The repetition rates are set at rates such that signal wrap-around does not occur. In addition, the rates are sufficient to pulse the transducer at least six times within the time necessary to move one-half the transducer dimension parallel to the scan direction at maximum scanning speed.



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7.0 CALIBRATION

7.1 Verification of Instrument Linearity

Instrument alignment verification for screen height and amplitude control should be performed within three (3) months prior to use of the instrument or at the beginning and end of each outage period, whichever is less. Instrument linearity verification is independent of transducer or scanner characteristics. Verification with one transducer/scanner combination is valid for any other combination. The due date for alignment verification shall be recorded on the calibration sheet.

7.2 System Parameters

The system parameters used for calibration and examination should be established as outlined in Reference 4.5 as required. The system should be operated in the T-SCAN program for thickness mapping and zero degree inspection and in the P-SCAN program for crack detection, weld inspection and/or additional evaluation.

7.3 General Requirements

- 7.3.1 Calibration shall include the <u>complete ultrasonic examination system</u>.

 Any change in transducers, wedges, couplants, cables, instruments, recording devices, scanners, power source, personnel, or any other parts of the examination system shall be cause for system calibration check.
- 7.3.2 If a secondary ultrasonic system is to be used, it must be calibrated before the inspection is started and not removed from the examination system during the inspection or recalibration will be required.
- 7.3.3 System calibration checks and final calibration for instrument sensitivity and sweep range shall be performed on the same block used for initial calibration using at least one reflector. These checks shall be performed:
 - a) At the start and finish of each series of examinations.
 - b) At intervals not to exceed 16 hours.
 - c) When there is a change as described in 7.3.1.
 - d) If the examiner suspects a malfunction.
- 7.3.4 If the horizontal sweep, thickness, or "Z" positions have changed more than 5% of the nominal thickness, void all examinations performed after the last valid calibration verification, and reexamine the voided areas.
- 7.3.5 <u>Calibration checks</u> may be performed on either a reference block or the basic calibration block, but must include a check of the entire examination



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system. Calibration checks may be accomplished by static or dynamic calibration.

- 7.3.6 Simulated calibration checks may be used in lieu of calibration checks where the spread of contamination or serious time constraints would result from performing a standard calibration check. Simulated calibration will use blocks, cables, or transducers of similar types and lengths as those used for testing and will be documented on the calibration data sheet. A baseline, simulated calibration shall be performed immediately after performing the initial calibration, or after a calibration check where the entire examination system is utilized. The initial simulated calibration check values are independent of the values obtained utilizing the entire examination system. The established tolerance applies to the subsequent simulated calibration checks.
- 7.3.7 During calibration, the temperature of the calibration block should be within 25 degrees Fahrenheit of the ambient inspection temperature.
- 7.4 Calibration Process for Thickness Mapping / T-scan

The basic process for calibration is the same for thickness mapping (T-scan), weld inspection, flaw detection, and sizing. The calibration reflectors for straight beam are the backwall reflections from a step wedge. The reflectors for angle beam transducers are the notch base and tips from a notched block. The calibration process is as follows:

- 7.4.1 Select and connect the appropriate transducer(s), input the parameters, including thickness, frequency, index delay, gates, inspection method(s), and velocity. Apply the couplant to the applicable points on the calibration standard. (Select a sufficiently thin step for detection of unexpected low reading or pits and a step greater than the maximum thickness expected.)
- 7.4.2 Place the transducer(s) on the 1.00" calibration step and adjust the gain control to produce a reflection of 80% full screen height (FSH). Input this gain level as the reference level. Obtain a response from the 0.300" calibration step, and verify that it produces an acceptable signal. Other thickness ranges may be used for system calibration. Initial calibration accuracy will be within +/- 0.010" in T-scan. Record reading on the Automated Ultrasonic Thickness Calibration Sheet (Attachment 1).
- 7.4.3 The vital parameters used for the calibration shall be identical to the inspection parameters with the exceptions of file name(s), X, Y and Z ranges, reference level compensations, thickness, gates or comment parameters which may be adjusted as required.



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- 7.5 Calibration Process for Weld Inspection / Crack Detection / P-scan
 - 7.5.1 Select and connect the appropriate transducer(s), input the parameters, including thickness, frequency, index delay, gates, inspection method(s), and velocity. Apply the couplant to the applicable points on the calibration standard. The 5%T notch on a 1" thick plate should be used to obtain the reference level.
 - 7.5.2 Manipulate the transducer to receive the maximum response from the reference notch. Adjust the gain control to produce a reflection of 80% full screen height (FSH). Input this value as the reference level. Obtain a response from the calibration reflector and verify that the response is within +/- 2dB.
 - 7.5.3 Repeat step 7.5.2 as required for each transducer until the system is calibrated.
 - 7.5.4 The vital parameters used for the calibration shall be identical to the inspection parameters with the exceptions of file name(s), X, Y and Z ranges, reference level compensations, thickness, gates or comment parameters which may be adjusted as required.
- 7.6 Sizing Calibration for Tip Diffraction Techniques (AATT, RATT)
 - a) Select an appropriate transducer.
 - b) Select a sizing calibration block of similar thickness and material containing at least two notches of known depths.
 - c) For the AATT technique, set at least two gates, to cover the entire area of interest. The first gate in the first leg, ending just before the ID. Position the transducer on the calibration block. Alternately peak the shallow and deep signals from the notch tips (see Figure 1, Attachment 2). Using the index delay and velocity controls, adjust the system until the system correctly reads the remaining ligament with the "Z" cursor.
 - d) For the RATT technique, the system mode should be set to A-SCAN.

 Manipulate the transducer until signals are obtained from the shallow notch tip and the notch base simultaneously (see Figure 2, Attachment 2). Using the index delay and velocity, adjust the distance between the two signals to read the actual reflector depth in inches. Repeat the same process on the deep notch. Alternate this procedure until the screen/system represents a desirable linear depth screen in inches.



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e) Save the calibration, and record this data on the Automated Ultrasonic P-Scan Calibration Sheet (Attachment 3).

8.0 EXAMINATION

8.1 Surface Condition

- 8.1.1 The surface from which measurements are to be taken should be free of loose scale, unbonded coating, heavy oxidation, weld spatter, or other material which may interfere with movement of the transducer or the transmission of sound into the material.
- 8.1.2 A surface finish of 250 RMS or better should be provided. The requesting organization must approve the use of any base material preparation process, which may reduce the thickness below the allowable tolerance.

8.2 Extent of Examination

The location of the areas to be measured and/or the number of scans to be performed shall be designated by the applicable work instructions. The location, scan numbers, and reference points of all scans shall be recorded on the applicable data sheets. See Attachment 4 for minimum examination volume and beam direction for weld inspection.

NOTE: Additional scan areas will not require revision to this procedure.

8.3 Flaw Location

When performing examinations to detect planar flaws, angle beam transducers shall be used. Calibration is performed as in Section 7.5. All angle beam examinations shall be performed in P-scan.

8.4 Ultrasonic Measurement

User calibration shall have been completed per the applicable requirements of Section 7.0 prior to performing any of the examinations.

- 8.4.1 Transducer overlap between passes shall be a minimum of <u>50%</u> of the element size. Scanning speed shall not exceed <u>6 inches</u> per second.
- 8.4.2 Should measurements be observed larger or smaller than the calibration range, check the calibration for accuracy in the encountered thickness range. If the calibration is accurate in this range, amend the calibration sheet and continue the examination. If the calibration is not within the



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tolerance allowed in the spec, then <u>recalibrate and rescan</u> all areas where readings were encountered outside the originally calibrated range.

8.5 Limitations and Precautions

- 8.5.1 Care must be taken to ensure the transducer face is flush with the examination surface during scanning.
- 8.5.2 When it is necessary to determine the origin of mid-wall indications, a 4MHz shear wave transducer(s) may be used in the P-Scan program to detect pit openings or perpendicular connections between laminar indications.

8.6 Recording

Upon completion of each scan area, the data file(s) shall be recorded on a disk. All measurements within the predetermined gated area are stored, along with the text information with each file.

8.7 General Sizing Guidelines

- 8.7.1 It is recognized that, of the methods of sizing described in this procedure, no one technique is completely accurate in sizing all flaws in all thicknesses. By using complementary methods, however, a realistic approximation of the flaw depth can be obtained.
- 8.7.2 The method of sizing pits is primarily utilizing a 0° dual element transducer. The 45° shear wave transducers may be used to confirm qualitatively the depth of the pit.
- 8.7.3 When sizing crack-like indications, the entire flawed area shall be scanned with the imaging mode. The entire flaw length shall be evaluated. It is recommended that A-Scans be recorded at the deepest location of the flaw. The primary technique for sizing crack-like indications is the high frequency, 45° shear wave transducer utilizing the Absolute Arrival Time Technique (AATT). The dual element, straight beam may be used as a complimentary technique.
- 8.7.4 Additional sizing technique sequences may be utilized if the primary techniques identified prove to be indeterminable.



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- 8.8 Sizing with Tip Diffraction Techniques (AATT, RATT)
 - 8.8.1 The AATT technique uses shear waves to obtain a diffracted echo (satellite pulse) from the flaw tip (see Figure 1, Attachment 2). The RATT technique uses shear wave reflected signals from both the flaw tip and the flaw base (see Figure 2, Attachment 2). Both techniques can be utilized using the same transducer.

a) AATT Technique

Locate the deepest extremity of the flaw and maximize the signal from the flaw tip. The distance to the flaw tip represents the remaining material ligament from the outside surface. To determine the relative through wall flaw depth, subtract this dimension from the local material wall thickness.

b) RATT Technique

Locate the deepest extremity of the flaw, and obtain a signal from the flaw base. Manipulate the transducer until the doublet (flaw base and tip signal appearing simultaneously) is observed. These signals do not have to be peaked, as the doublet separation directly indicates the relative through wall depth. To determine remaining material ligament, subtract the relative through wall depth measurement from the local material wall thickness.

8.8.2 Other sizing techniques or variations to the techniques may be used with the approval of the UT Level Ill. Such approval, signature and a description of the technique shall be recorded in the "Remarks" column on the Automated Ultrasonic P-Scan Calibration Sheet (Attachment 3).

9.0 EVALUATION

9.1 Relevant Indications

Relevant Indications, including pitting, thinning and crack-like indications, along with the minimum thickness reading in the area of interest, shall be recorded and used for evaluation per Paragraph 9.2.

9.1.1 P-scan data shall be evaluated to a sensitivity of 20% reference level (-14dB). All crack-like indications are recordable regardless of amplitude.



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- 9.1.2 T-scan data shall be evaluated utilizing all available images to detect and evaluate indications.
- 9.1.3 Reportable indications shall be evaluated by Level III personnel prior to final report submittal.
- 9.2 Reporting/Special Criteria

Reporting and special notification criteria are noted in Section 9.8.

9.3 Statistical Information

The statistical information (Minimum and Mean thickness) provided under "Setup" pages 1 & 2 of the post-processing software should be reported for each "Part" of a given scan location. Where data noise invalidates these values, the analyst should determine the values using the level control.

9.4 Printouts

Printouts should be made in accordance with the customer's request. In absence of further direction, both the merged set-up pages and the merged image, adjusted to show the minimum thickness, shall be printed at a level that best shows the wear patterns or at Nominal T - 10.0%, whichever provides the most useful information. P-scan data should be printed with the level control set at 20% reference level (-14dB).

9.5 Recording Crack Size

- 9.5.1 All flaw sizing data acquired should be used to determine the flaw depth.

 This data shall be reported individually for each flaw and shall include all data necessary to achieve the best accuracy of flaw depth.
- 9.5.2 If, during sizing, a <u>flaw length other than that reported during the detection examination</u> is measured, or other discrepant conditions occur, record the corrected lengths, locations. or distances on the Automated Ultrasonic P-scan Data Report (Attachment 5) in the spaces provided.
- 9.5.3 If, during sizing, the area is determined <u>not to be flawed</u>, and the resultant reflector(s) is due to component/weld geometry or metallurgical structure, the true origin (e.g., root, mismatch, etc.) shall be documented and substantiated on the Ultrasonic P-scan Data Report.

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9.6 Scanning Limitations

Record all limitations due to weld configurations, obstructions, single side access restrictions, etc., in the remarks section on the applicable Ultrasonic Data Report. Details as to specific length or area in relation to L (X) and/or W (Y) reference points should be recorded.

9.7 Flaw Evaluation

Reportable indications shall be evaluated by Level III personnel prior to final report submittal.

9.8 Reporting Levels

All indications which meet or exceed the following conditions shall be reported to the project cognizant engineer.

- a) Pit depth exceeds 25% of the wall thickness.
- b) Wall thinning exceeds 10% of the wall thickness.
- c) Surface crack depths exceeding 0.100 inches.



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10.0 REPORTS

10.1 Thickness Data Reports

An Automated Ultrasonic Thickness Data Report (Attachment 6) shall be prepared for each examination or series of examinations performed. This report shall include identity of equipment, the thickness measurements obtained, and should be referenced to the calibration sheet.

10.2 Calibration Reports

An Automated Ultrasonic Thickness Calibration Sheet (Attachment 1), and an Automated Ultrasonic P-Scan Calibration Sheet (Attachment 3) shall be prepared for each examination or series of examinations performed. These reports shall include the materials and equipment used for examination.

10.3 Sketch Sheets

Automated Ultrasonic Examination Sketch Sheet(s) (Attachments 7 and/or 8) should be prepared for each examination or series of examinations performed. These reports should include a sketch of the component or item examined, identifying scan locations, including dimensions, reference points, and grid locations, where applicable.

10.4 Sizing Data Reports

An Automated Ultrasonic P-Scan Data Report (Attachment 5) shall be completed only when cracking is detected. Each report shall be related to the applicable Automated Ultrasonic Examination Calibration Sheet(s).

10.5 Final Reports

Final reports are to be distributed and maintained in accordance with the applicable contract.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

11.0 ATTACHMENTS

Attachment 1: Sample Automated Ultrasonic Thickness Calibration	Sheet
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Attachment 2: Figure 1: Absolute Arrival Time Technique (AATT)

Figure 2: Relative Arrival Time Technique (RATT)

Attachment 3: Sample Automated Ultrasonic P-scan Calibration Sheet

Attachment 4: Examination Volume, Minimum Beam Directions and Extent of

Examination

Attachment 5: Sample Automated Ultrasonic P-scan Data Report

Attachment 6: Sample Automated Ultrasonic Thickness Data Report

Attachment 7: Automated Ultrasonic Examination Sketch Sheet - Tank Walls and

Knuckles

Attachment 8: Automated Ultrasonic Examination Sketch Sheet – Tank Bottom



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 1: Sample Automated Ultrasonic Thickness Calibration Sheet

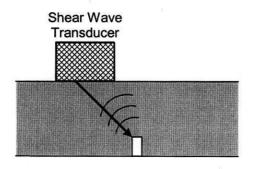
AU'	TOMATED ULT		HICKNESS			Riser		
Location:		Syste	em:	Calibratio Block:	on			
Procedure:			Rev.	Thickness	s:	Material:		
UT System:		Serial No.		Reference Block:	е	<u> </u>	14-19	
Software Ve	ersion:		Rev.	Thickness	s:	Material:		
Linearity Du	e Date:			Referenc	e Block Temp:	°F		
Scanner Typ	pe:	Serial No.	TFAL	Couplant		Batch No.	7-10-	
Scanner Ca	ble:			Cable Lei	ngth:	Feet		
Signal Cable	e:	·		Cable Le	ngth:	Feet		
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\vdash	K. 2					 _		
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Examiner:		Exami	ner:		Reviewer	•		
Level:		Level:	Date: _		Level: Date:			

Rev. Dec. 03, 2003



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 2: Absolute Arrival Time Technique (AATT) & Relative Arrival Time Technique (RATT)



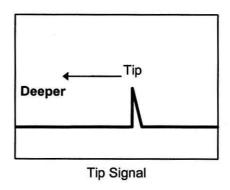
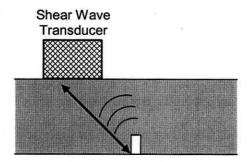
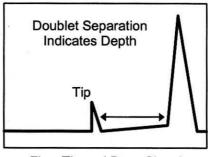


Figure 1. Absolute Arrival Time Technique





Flaw Tip and Base Signal

Figure 2. Relative Arrival Time Technique



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

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	Al	JTOI	MATED UL CALIBRA					Job#			Riser#		
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UT Sys	tem:			Seria	il No.	<u> </u>		ference Block:			•	<u>. </u>	
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Linearit	y Due	Date:		<u> </u>		<u> </u>	Re	ference B	lock Temp:		<u> </u>		
Scanne	ег Туре	 ∋:		Seria	ıl No.	· · ·	Co	uplant:		В	Batch No.		
Scanne	er Cab	le:		<u> </u>		·	Ca	ble Length	h:		Feet		
Signal (Cable:						Ca	ble Length	h:		eet		
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Level:	Level: Date:					Level: Date:				Level: Date:			

Rev. Dec. 03, 2003



0° T-Scan

COGEMA-SVUT-INS-007.3, Rev. 2 UNCONTROLLED COPY

AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 4: Examination Volume, Minimum Beam Directions and Extent of Examination Primary Knuckle Horizontal T-Scan Strip: 0° T-Scan, 20' Length Weld Examination Volume: ~1 in. The examination volume is 1" on each side of the weld for the lower 3/4T. When the probes are parallel to the weld, scan a 1" wide area as close to the toe as possible. 3/4T Weld **Primary Wall Primary Wall** Vertical Weld Vertical T-Scan / P-Scan Strips: Inspection: 45° P-Scan 0° T-scan and directions 45° P-scan strips, 0° T-Scan and 2 each 15" 60° P-Scan Secondary Wall **Annulus** Horizontal Weld Inspection: 45° P-Scan 60° P-Scan 0° T-Scan **Primary Primary** Tank Wall **Primary Knuckle** Horizontal T-Scan Strip: 0° T-Scan and 45° P-Scan Secondary Knuckle: 45° P-Scan Primary Bottom Inspection via Slots: 0° T-Scan and 45° P-Scan **Secondary Bottom:**



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 4 (continued): Extent of Examination

Primary Tank Wall

<u>Vertical Strips</u> - Examine a vertical strip 30" x 35 feet long of the primary wall between the upper haunch transition and the lower knuckle for pits, cracks and wall thinning. Axial cracks on the tank inner wall surface shall be detected and sized. The vertical strip may be comprised of one or more strips whose total width is equal to 30 inches.

Weld Areas - Examine 20 feet of horizontal weld area (heat affected zone), at tank to knuckle weld. Examine one \sim 10 foot section of vertical weld joining the lowest shell course plates and one \sim 10 foot section of vertical weld joining the next to lowest shell course plates. Axial and circumferential cracks on the tank inner surface shall be detected and sized.

Primary Tank Knuckles

Examine 20 feet of the primary tank lower knuckle in the circumferential direction to detect and size cracking in the circumferential direction and to detect pits and wall thinning. Examine 20 feet of the primary tank upper knuckle in the circumferential direction to detect pits and wall thinning. The areas to be examined are from the welds joining the transition plates with the knuckles to the furthest reach of the transducer assembly that is allowed by geometric constraints.

Secondary Tank

<u>Secondary Tank Lower Knuckle</u> – Examine a 20 foot length of the secondary tank knuckle over the entire area of the knuckle for the presence of circumferential cracks.

<u>Secondary Tank Bottom</u> – Examine the secondary tank bottom over an area of 10 ft² to detect and measure thickness and pits.

Primary Tank Bottom

Examine the primary tank bottom for pits, wall thinning and cracks oriented in the circumferential direction (perpendicular to the air channels) in 16 air channels. The tank bottom is to be examined for a distance of 12 feet towards the tank center, starting seven inches inboard of the outside radius of the tank cylindrical section. The primary tank bottom scan head is designed to examine the accessible area in the air channel in one pass through the channel.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 5: Sample Automated Ultrasonic P-scan Data Report

	AUT	OMATE	D ULTR	RASO	NIC P-S			_	ob #	,5		Riser	#	
Loca	ition:				System:		Ex	am	Start:			Exam	End:	
Com	ponent ID:					17.723	Ex	(ami	nation Sur	face:	ED	Nomii Thicki		
Conf	figuration:			ТО				alibra		то		7	emp:	٥F
Tota	I Length Exa	mined:	· .		Scan Width	า:			evel Corre	ction (Tra	ans. Co	orr):		DB
Proc	edure:			L	·.	Rev.			al Type:	OTHER:			Conditio	
/ Iter							Tr		lucer:		0 DEG	; <u> </u>	ANGLE:	0
X _O F	lef. Point (Lo):												
Y _o F	tef. Point (W	o):												
	Sizing Meth	od	Angle (d	leg)	Refere	ence Cal.	Sheet	-		Set-	Up / F	ile Nar	ne	
1	45° SHEAR			-				_						
2	60° SHEAR													
3	AATT		•••				.,							
4	DUAL 0 ^O													
						TION IN								
Ind.	Method	Weld Side	Depth R. Lig.	Max. Amp.	4	Lengt (in)			W1 (in)	Width (in)		V2 in)	Indicatio	п Туре
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Rer	narks:						,				•	-·· <u>·</u>		
Exa	miner:		Exan	niner:			Analyst:	:			Revie	ewer:		<u> </u>
Leve	el:			Date	ate: Leve			evel:			Level:			

Rev. Dec. 03, 2003



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 6: Sample Automated Ultrasonic Thickness Data Report

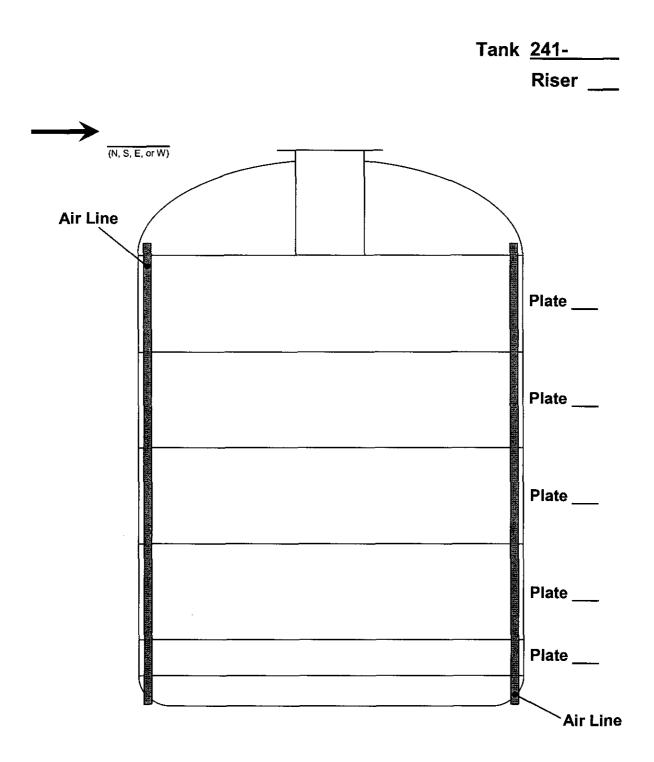
	ATED UL		VIC THICK		3101	Job #		Riser#		
Location:					E	xam Start:		Exa	am End:	
Component ID:					1_	xamination Surfa	ce:		minal ckness:	
Configuration:		ΤO			R	alibrated ange:	то		Temp:	°F
Total Length Exami	ned:		Scan Width:			ef. Level Correct	ion (Trans. 0	Corr.):		DB
Procedure:				Rev	1	laterial Type: □ SS □ CS O	THER:		Cond	ition:
File Name:						ransducer:	GL 🖾 0 DE	EG	☐ ANGLE	· · · · ·
X _o Ref. Point (L _o):										
Yo Ref. Point (Wo):									• • • • • • • • • • • • • • • • • • • •	
Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)		Stop (in)	Ave. Thk. (in)	Min. Thk. R. Lig. (in		Area eportable	Max. Thk. (in)
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Remarks:										
Examiner: Examiner:					Analyst: Reviewer:			er:		
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Rev. Dec. 03, 2003



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 7: Automated Ultrasonic Examination Sketch Sheet - Tank Walls and Knuckles





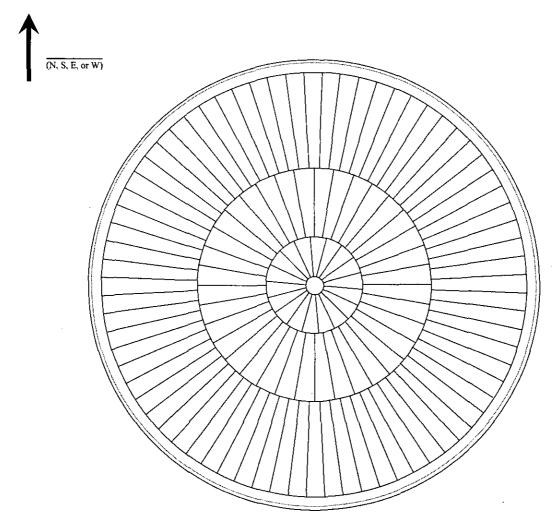
AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 8: Automated Ultrasonic Examination Sketch Sheet - Tank Bottom

Tank <u>241-</u>

Typical Air Channels Under Tank Bottom

Note: Flow Path Geometry and Number of Channels Differ from Tank to Tank



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ATTACHMENT 2

COGEMA "AUTOMATED ULTRASONIC THICKNESS DATA REPORT SHEETS"

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AUTOMA	ATED ULT DATA	RASONIC REPORT		NESS		5					
Location: 200 EA	AST TANK	FARM			Exa	m Start: 04/04/05	1016	Exam End:	1954		
Component ID:	AN103					mination Surfa		Nominal Thickness:	0.5"		
Configuration:	PLAT	E TO P	LATE		Cal Rar	ibrated nge: 0	.3" TO 1.0"		AMB ^O F		
Total Length Exam	ined: 90.4	, s	can Width:	15"	Ref	Level Correcti	on (Trans. Co	эт.):	O DB		
Procedure: CO	SEMA SVU	T-INS-007.	3	Rev 2		terial Type: SS ⊠ CS O	THER:	Cond	ition: N/A		
File Name:	VERT	.WALL/PL	ATE 1		Transducer: o ☑ DUAL ☐ SGL ☑ 0 DEG ☐ ANGLE;						
Xo Ref. Point (Lo):		HORIZON		LD, SCA							
Yo Ref. Point (Wo)		INE OF 24	···								
Part # / Indication	X Start (in)	X Stop (in)	Y Star	t YS		Ave. Thk.	Min. Thk., R. Lig. (in)	Area Reportable	Max, Thk. (in)		
0 - 12	(81)	(11)	(11.7)		<u>"</u>	.534	.512	Reportable	.548		
12 - 24						.537	.510		.548		
24 - 36					-	.539	.519		.548		
36 - 48					•	.539	.513		.548		
48 - 60						.539	.512		.548		
60 - 72						.540	.486		.548		
72 - 84						.536 .510					
84 - 90,4						.531	.509		.547		
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	Remarks: Peak-Edge Contact Thickness Data										
Lunga	Examiner: W. H. Nelson Examiner:						Rev	riewer: W. H.	Nelson		
at f leter					an	CIL)/NE	$\Rightarrow \omega $	HILLE	<u></u>		
Level: III Date: _	<u>4/4/05</u>	Date):	Lé	vel: <u>l</u>	II Date: <u>06/25</u>	5/05 Lev	rel: <u>III</u> Date:	7(17/6)		
COST A MITTIES AN											

AUTOMA		RASON A REPOR	IC THICK! RT	VESS			1-41	Riser #	5		
Location: 200 EA	AST TANK	FARM			Еха	m Start: 04/11/05	1008	Exam End:	2011		
Component ID:	AN103					mination Surfa		Nominal Thickness:	0.5"		
Configuration:	PLA'	TE TO	PLATE		Cal	hratori	.3" TO 1.0"		AMB ^O F		
Total Length Exami	ined: 89.3	4	Scan Width:	15"		. Level Correct	on (Trans. C	orr).	0 DB		
Procedure: COC	SEMA SVU	·····	7.3	Rev 2		terial Type: ISS ⊠CS O	THER:	Cond			
File Name:	VER'	Γ.WALL/P	LATE 2		Transducer: ☑ DUAL ☐ SGL ☑ 0 DEG ☐ ANGLE:						
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Yo Ref. Point (Wo):			24" RISER		······································						
Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)	Y St		Ave. Thk. (in)	Min. Thk., R. Lig. (in)	Area Reportable	Max. Thk. (in)		
0-12						.519	.496		.533		
12 - 24						.521	.501		.533		
24 - 36						.522	.501		.533		
36 - 48						.522	.500		.533		
48 - 60						.522	.497		.533		
60 - 72						.522	.500		.533		
72 - 84					.521 .499			.533			
84 - 89,3						.521	.499		.533		
								 			
		-									
		1									
Remarks: Peak-Edge C	Remarks: Peak-Edge Contact Thickness Data										
	Examiner: W. H. Nelson Examiner:						Apalyst: J. B. Elder Reviewer: W. H. Nelson				
WHI LE	WHRen					James Sol WHO Zee					
Level: <u> </u> Date: _	Level: <u>III</u> Date: <u>4/11/05</u> Date:						Level: III Date: 7/4/05 Level: III Date: 7/17/6				

COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 6

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AUTOM		TRASONIC A REPORT		SS		Job# O4	1-41	Riser # 25			
Location: 200 EA	AST TANK	FARM			Exa	m Start: 04/12/05	0826	Exam End:	1441		
Component ID:	AN103		,, 			mination Surface	ce:	Nominal Thickness:	0.5"		
Configuration:	PLA'	TE PI	.ATE		Cali	hmtad	3" то 1.0 "	T ======	AMB ^o F		
Total Length Exami	ned: 89.4	" Sc	an Width:	15"		Level Correcti	on (Trans. Co	orr.):	O DB		
Procedure: COC	SEMA SVU	T-INS-007.3	Re	2		lerial Type: ISS ⊠ CS O⊓	THER:	Cond			
File Name:	VER	ſ.WALL/PLA	TE 3		Tra	nsducer:		G ANGLE	0		
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12 - 24						.521	.496		.533		
24 - 36						.522	.498		.532		
36 - 48						.523	.501	i i	.533		
48 - 60						.523	.499		.532		
60 - 72						.521	.495		.532		
72 - 84					.519 .494			.532			
84 - 89.4					.517 .489				.532		
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Remarks: Peak-Edge C	Remarks: Peak-Edge Contact Thickness Data										
Examiner: W.H.		Examiner:		An:	liyst: Qvn	J. B. Elder D. D. ZUG	Rev	riewer: W.H.	Nelson		
Level: Date: 04/12/05 Date: Level: Date: 06/25/05 Level: Date: 7/ 17/05											
COGEMA-SVUT-INS-007	COGEMA-SVUT-INS-007.3, Rev. 2 Attachment 6 Rev. Dec. 03 2003										

AUTOM	ATED ULT DATA	RASONIA REPOR		VESS			4-41	Riser# 25			
Location: 200 E/	AST TANK	FARM			Exa	m Start: 04/15/05	1039	Exam End:	2044		
Component ID:	AN103					mination Surfa ☑ OD ☐ ID ☐		Nominal Thickness:	0.75"		
Configuration:	PLAT	re ^{to} i	PLATE		Cal	ibrated	.3" то 1.0"	Temp:	AMB ^O F		
Total Length Exam	ined: 104.	6"	Scan Width:	15"		. Level Correct	on (Trans. Co	оп.):	0 DB		
Procedure: CO	GEMA SVU	T-INS-007	.3	Rev 2	Ma	terial Type: ISS ⊠CS O	THER:	Conc	lition: N/A		
File Name:	VERT	r.WALL/PL	ATE 4		Tra	nsducer:		∃ ☐ ANGLE	٥		
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Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)	Y St		Ave. Thk. (in)	Min. Thk., R. Lig. (in)	Area Reportable	Max. Thk. (in)		
0 - 12						.756	.729		.770		
12 - 24						.755	.733		.771		
24 - 36					····	.754	.735		.769		
36 - 48						.754	.735		.771		
48 - 60			1			.754	.733		.769		
60 - 72						.754	.735		.769		
72 - 84						.752	.728		.770		
84 - 96						.753	.726		.771		
96 - 104.6						.752	.731		.771		
Remarks: Peak-Edge Contact Thickness Data											
Examiner: W.H.	1	Examiner:		April	alfst:	J. B. Elder	Rev	viewer: W.H.	Neison		
Level: Date: 04/15/05 Date: Level: Date: 06/25/05 Level: Date: 7/17/05											
COGEMA-SVUT-INS-007	.3. Rev. 2. Attach	ment 6				. — —		S.	v. Dec. (13. 2003		

AUTOMA		RASONIC AREPOR	THICKNE T	SS		25				
Location: 200 EA	ST TANK	FARM			Еха	m Start: 04/13/05	0905	Exam End:	1930	
Component ID:	AN103					mination Surfa		Nominal Thickness:	0.875"	
Configuration:	PLA	TE TO F	LATE		Cal	bratad	.3" to 1.0'	Tome	AMB °F	
Total Length Exami	ned: 21.2	. 8	ican Width:	15"	Ref	Level Correct	ion (Trans, C	Corr.):	O DB	
Procedure: COC	SEMA SVU	T-INS-007	3 Re	^v 2	Material Type: Condition: SS ⊠ CS OTHER: N/A					
File Name:	VER	Γ.WALL/PL	ATE 5			nsduce r: DUAL ☐ SC	SL 🖾 O DE	G 🗆 ANG	E: •	
Xo Ref. Point (Lo):	1" BELOV	V HORIZO	NTAL WELD		L					
Yo Ref. Point (Wo):	CENTER	LINE OF 24	I" RISER							
Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)	Y Sto (in)		Ave, Thk.	Min. Thk., R. Lig. (in)	1	Max. Thk.	
0 - 12						.883	.850		.896	
12 - 21.2						.884	.846		.896	
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Remarks: Peak Contac	t Thickness	s Data	·				•			
Examiner: W. H.	Examiner: W. H. Nelson Examiner:						Analyst: J. B. Elder Reviewer: W. H. Nelson			
Level: <u>III</u> Date: _	Level: 111 Date: 04/13/05 Date: Le					Date: <u>7/2/0</u>	<u>5</u> Le	vel: <u>III</u> Date	: 7/17/05	

Rev. Dec. 03. 2003

COGEMA-SVUT-INS-007,3. Rev. 2. Attachment 6

AUTOMATED ULTRASO DATA REPO		Job# Riser# 25								
Location:	System:	Ехал	n Start:		Exan	n End:				
200 EAST TANK FARM	PSP-4		04/04/05			1957				
Component ID: AN103		⊠c	nination Surfi			mess: 0.5000"				
Configuration: PLATE	PLATE	Rang		0" to 1.41"		Temp: AMB ^O F				
Total Length Examined: 90.4"	Scan Width: 15"	1		tion (Trans. C	Соп):	<u>0</u> DB				
Procedure: COGEMA SVUT-INS-00	7.3 Rev. 2	Material Type: Condition: N/A								
File Name / VERT.WALL/F	LATE 1		sducer: DUAL [] S	GL 0DE	:G [ANGLE: 45°				
Y- Ref Point (1-)	ONTAL WELD, SCAI	·····								
Yo Ref. Point (Wo): CENTERLINE OF										
Sizing Method Angle (deg)	Reference Cal. She	et		Set-Up /	File Na	ame				
1 45° SHEAR										
-2 60° SHEAR										
3 AATT										
4 DUAL DO			<u></u>							
	INDICATION INFO			1 w 1						
Ind. Method Weld Depth Ma Side R. Lig. Am		L2 (in)	W1 (in)	Width (In)	W2 (in)	Indication Type				
				 						
		 								
		····								
Remarks:										
Remarks: No Cracklike Indications										
Examiner: W. H. Nelson Examiner:	Æn	alyst: J	. B. Elder	Re	vlewer:	W. H. Neison				
WDDer_	(Dru	N	1/4	10	Tee_				
Level: III Date: 04/04/05 D	ate: Le	Level: Date: 7/4/05 Level: Date: 7/17/2				Date: 7 17 05				
COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 5	<u> </u>					Rev. Dec. 03, 2003				

	AUTO	SCAN		Jol	ь# О	4-41	Rise	er# 2:	5				
Loca	ition:	AST TA	NK FARM	,	System:	PSP-4	Exa		start: 14/11/05	0934	Еха	ım End:	2006
Com	ponent ID:			•		ror		min	ation Surfa	ice:		ninal	0.5000"
Conf	figuration:	AN103		TO				OD ibrat	lori	PAINTED		Ckness: Temp:	
	l Length Exar	mined	PLATE		PLATE Scan Width		Da	nge: f. Let		" TO 1.41 ion (Trans.		<u> </u>	AMB °F
			89.3*			15'	"		il Type:	1011 (1.2.2.			0 DB dition:
)GEMA	SVUT-INS	S-007	'.3	Rev. 2	2 [] SS	⊠ics o	THER:		5011	N/A
File / Iter	Name m #:	1	VERT.WA	LL/PI	LATE 2			I nsd i DU	ucer: JAL 🏻 So	GT □0D	EG	⊠ ANGL	E: <u>45</u> °
X _o F	Ref. Point (L _o)): 1" BE	ELOW HO	RIZC	NTAL W	ÆLD			****				
Yo Ref. Point (Wo): CENTERLINE OF 24" RISER													
	Sizing Metho	od	Angle (de		Set-Up	/ File N	lame						
1	45° SHEAR												
2	60° SHEAR	-	1					+			-,-, ,		
3	DUAL 0°						······································	+		 			
┝╌	DOALO			لــــــــــــــــــــــــــــــــــــــ	INDICA	ATION IN	IFORMA	TIO	N				
ind.	Method	Weld	Depth	Max.	•	l.eng	th LZ		W1	Width	W2	Indi	cation Type
		Side	R. Lig.	Amp). (in)	(in)	(in)	(ln)	(in)	(in)	+	
		 	1			1	-						***
		 	-									+	
			1									+	
		<u> </u>	<u> </u>	<u> </u>									
		ļ		<u> </u>									
	morke:			L					<u> </u>				
1	Remarks: No Cracklike Indications												
4	aminer: W. H <i>VL) T</i> Le vel: <u>III</u> Date:	<u></u>		niner: Dat	te:		Jan	us)	3. Elder S 200 pate: _7/4/0	4	W	-	Nelson 7/17/05
				,,		_					_		

COGEMA-SVUT-INS-007.3, Rev. 2. Affectiment 5

Rev. Dec. 09. 2003

-	AUTO		D ULTR ATA RE		NIC P-SO T)4-41	Riser#	25			
Loca		AST TAN	NK FARM		System:	SP-4	Exan	n Start: 04/12/05	0846	Exam	End: 1455		
Com	ponent ID:	AN103						nination Surf	ace: I PAINTED	Nomin: Thickn			
Conf	iguration:	F	PLATE	TO F	PLATE			rated	0" TO 1.41	T T	emp: AMB OF		
Tota	Length Exar	nined:	89.4"		Scan Width:	15"	Ref.	Ref. Level Correction (Trans. Corr):					
Proc	edure: CO	GEMA S	SVUT-INS	S-007.	.3	Rev. 2		rial Type: SS ⊠CS	OTHER:		Condition: N/A		
File / iter	Name n #:	٧	ERT.WA	LL/PL	ATE 3			sducer: DUAL []	SGL 🗆 0 E	EG 🖾	ANGLE: 45°		
X _o Ref. Point (له): 1" BELOW HORIZONTAL WELD													
Yo F	tef. Point (Wo): CENT	ERLINE	OF 24	4" RISER								
	Sizing Meth	od	Angle (de	- g)	Referer	heet		Set-Up	/ File Nam	10			
1	45° SHEAR												
2	60° SHEAR												
3	AATT									,.			
4	DUAL 0°				131151645	CONTRACT	OCHAT						
		Weid	Depth	Max.	INDICAT	Length		WI	Width	W2			
Ind.	Method	Side	R. Lig.	Amp.		(in)	(in)	(in)	(in)	(in)	Indication Type		
				······································			-		-				
				·			1		1				
	······································						-	-					
				·		1		1			· · · · · · · · · · · · · · · · · · ·		
ليرا		<u> </u>	<u> </u>			1	<u> </u>		<u>l </u>				
•	marks: Io Cracklik	e Indicat	ions										
1 .	miner: W. H	i, Neison	Exam	iner:		P	/ /	I. B. Elder	'A ! .		W. H. Nelson		
	el: <u>III</u> Date:	04/12/05		Date	e:	_ 2	7,6	Marie: 06/25/05 Level: Date: 7/1					

COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 5

AUTOMATED ULT DATA F	RASONIC REPORT		Job#)4-41	Riser # 25						
Location: 200 EAST TANK FAF	Syst	Exa	n Start: 04/15/05	1039	Exam End: 2044						
Component ID: AN103		PSP-4		nination Surf	ace:	Nominal 2 7 7 9 8 1					
Configuration: PLATE	TO PLA	TE	Call	DD ID D	1 PAINTED 0" TO 2.12"	Temp: AMB OF					
Total Length Examined: 104.6"		Width: 15	Ran Ref.	3	tion (Trans. C	com):					
Procedure:		Rev.	Mate	erial Type:		0 DB Condition:					
COGEMA SVUT-I	NS-007.3	2		SS ⊠CS (OTHER:	_ N/A					
7 POG-113 7F.	/ALL/PLATE		DUAL S	GL 🗆 0 DE	G ⊠ANGLE: 45°						
Xo Ref. Point (Lo): 1" BELOW I	ORIZONTA	AL WELD		·							
Yo Ref. Point (Wo): CENTERLINE OF 24" RISER											
Sizing Method Angle	(deg) i	Sheet		Set-Up /	File Name						
1 45° SHEAR	·										
2 60° SHEAR 3 AATT				ļ							
4 DUAL 0°		 									
	IN	IFORMAT	ION								
Ind. Method Weld Depth Side R. Lig.	Max. Amp.	L1 Leng (in) (in)		W1 (in)		W2 Indication Type					
·											
			·								
					 						
					-						
Remarks:					<u> </u>						
No Cracklike Indications											
Examiner: W. H. Nelson Ex	aminer:		Analyst: .	J. B. Eider	Rev	Reviewer: W. H. Nelson					
WHIRE -	·-··		June	HYXVE		WD Mer					
Level: <u>III</u> Date: <u>04/15/05</u>	Date:		/ Level: <u> </u>	Date: <u>06/2</u>	5/05 Lev	Level: III Date: 7[17]05					
COGEMA-SVUT-INS-007.3. Rev. 2. Attachmer	ł 5					Rev. Dec. 03, 200					

	AUTO		D ULTR				Job # Riser # 25					5	
Loca		ACT TA	NK FARI	,	System:	PSP-4	Exa	m Sta	rt: /13/05	0901	Exa	em End:	4005
Com	ponent ID:			"		ror-4		minati	on Surf	ace:		minal	1925
Cont	iguration:	AN103	·	TO				☑ OD ☐ ID ☐ PAINTE			Thi	ckness: Temp:	0.8750"
			PLATE		PLATE			Range: 0" TO 2.47"					AMB °F
Tota	i Length Exar	mined:	21.2"] ;	Scan Width	^{1:} 15"	Ref	Ref. Level Correction (Trans. Corr): 0 DE					
Proc	edure: CO	GEMA :	SVUT-IN	S-007	.3	Rev. 2		Material Type: Condition: SS ☑ CS OTHER: N/A					
File / Iter	Name n#	,	/ERT.WA	LL/PL	ATE 5		nsduci DUAL		GL □01	DEG	⊠ ANGL	E: <u>45</u> °	
	Ref. Point (Lo)	1" BE	LÓW HO	RIZO	NTAL W								
Y ₀ F	Ref. Point (Wo	<u>3:</u>	TERLINE										
	Sizing Meth	od	Angle (d	eg)	Refere	Sheet			Set-U	/ File I	Vame		
1	45° SHEAR												
2	60° SHEAR							4					
3	AATT							-					
4	DUAL 0°	1			INDICA	TIONIN	FODMA.	FION					
		Weld	Depth	Max.		TION IN Lengt		HON	W1	Width	W2		
ind.	. Method Side R. Lig. Am					(in)	(in)		(in)	(in)	(in)	Indi	cation Type
									,				
			Ì										·····
													·
		<u> </u>	ļ										
						<u> </u>			-				
1	marks: Io Cracklik	e Indica	tions										
<u></u>				niner:									
Exa	miner: W. H		Analyst:	J. B. E 26		1.	Reviewe	r. W.H. Yek	Nelson				
Lev	ret: <u>III</u> Date:	04/13/05	5	Dat	e:		Level: <u>III</u>	Date	e: <u>07/0</u>	2/05 L	.evel; <u>[</u>]	Date:	7/17/25

COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 5

Rev. Dec. 03, 2003

	ATED ULT DATA	TRASONIC A REPOR		Job#	4-41	Riser# 25						
Location: 200 E/	AST TANK	FARM	· ·	Exa	m Start: 04/11/05	1016	Exam End:	1954				
Component ID:	AN103				mination Surfa	ce:	Nominal Thickness:	0.5"				
Configuration:	PLA ⁻	TE TO P	LATE		Cali	Calibrated Range: 0.3" TO 1.0" Temp: AMB OF						
Total Length Exam	ined: 90.6	" s	can Width:	Ref	Level Correct		orr.):	0 DB				
Procedure:	GEMA SVU	T-INS-007	3 F		terial Type:	EICO.	Cond	lition:				
File Name:		VALL/2 ND /P	Tra	nsducer:			N/A °					
X _o Ref. Point (L _o):						DUAL S	GL 🛛 0 DEG	ANGLE				
1" ABOVE HORIZONTAL WELD, SCAN UP Yo Ref. Point (Wo): 17" FROM CENTER OF 1 st . PASS												
Part # / Indication	X Start (in)	X Stop	Y Start (in)	Y Sto	•	Ave. Thk.	Min. Thk., R. Lig. (in)	Area Reportable	Max. Thk. (in)			
0 - 12				.539	.524		.545					
12 - 24						.541		.548				
24 - 36						.543	.522		.548			
36 - 48						.543	.519		.548			
48 - 60						.542	.505		.548			
60 - 72						.541	.515		.548			
72 - 84						.539	.517		.548			
84 - 90.6						.541	.519		.548			
· ·			<u> </u>									
		<u> </u>	<u> </u>									
						-						
						1						
						-						
Remarks:			1			<u></u>		<u></u>				
Peak-Edge contact thickness data												
Examiner: W. H	Examiner: W. H. Nelson Examiner: Analysi J. B. Elder // Reviewer: W. H. Nelson											
WATU				_ _	1/2	WB1SS		24 200	<u> </u>			
Level: III Date:	04/11/05	Date	•	Lev	_evel: III Date: 06/25/05 Level: III Date: 7170							

COGFMA-SVIIT-INS-007.3 Rev 2 Attachment &

Rev Dec 0.1 2003

AUTOMA	ATED ULT DATA	RASONI A REPOR		NESS		7op #	4-41	Riser #	5				
Location: 200 E/	AST TANK	FARM		Exa	m Start: 04/12/05	0837	Exam End;	1452					
Component ID:	AN103			Exa	mination Surfa	CE:	Nominal Thickness:	0.5"					
Configuration:	PLA'	TE TO	PLATE		Cal	Calibrated Range: 0.3" TO 1.0" Temp: AMB OF							
Total Length Exami		T	Scan Width:		Ref. Level Correction (Trans. Corr.):								
Procedure: COC	SEMA SVU		7.3		terial Type: ISS IXICS O	THER:	Con	dition: N/A					
File Name:	VERT.V	VALL/2ND	/PLATE 2	Tra	Insducer:		G DANGL						
Xo Ref. Point (Lo): 1" BELOW HORIZONTAL WELD													
Yo Ref. Point (Wo): 17 INCHES FROM CENTER OF 1 ST . PASS													
Part # / Indication	X Start (in)	X Stop (In)	Y Start (in)		top	Ave. Thk. (in)	Min. Thk., R. Lig. (in)	Area Reportable	Max. Thk. (in)				
0 TO -12						.523	.502		.533				
-12 TO -24						.527	.507		.533				
-24 TO -36						.525	.511		.533				
-36 TO -48		<u> </u>				.525	.503		.533				
-48 TO -60						.525	.509		.533				
-60 TO -72		:				.525	.509		.533				
-72 TO - 84						.525	.505		.533				
-84 TO -89.3					.525 .511				.533				
			_		· ·········								
					·····				-				
Remarks: Scan from To Peak-Edge C			ta				•	(.)	······································				
Examiner: W. H. WHY Dus						Analyst: J. B. Elder A. Reviewer: W. H. N							
Level: <u>III</u> Date: _	04/12/05	Da	te:	_ Le	ivel: _l	I Date: <u>7/4/0</u>	<u>5</u> Le	vei: <u>III</u> Date:	1/12/02				

COGEMA-SVUT-INS-007,3 Rev. 2 Attachment 6

Rev. Dec. 03, 2003

AUTOM		TRASONIO A REPOR		Job# O-	4-41	Riser#	5					
Location:	AST TANK	FARM		Exa	m Start: 06/02/05	0856	Exam End:	1921				
Component ID:	AN103	> \transfer \tag{1}{2}			mination Surfa	ce:	Nominal					
Configuration:		TO				⊠ 00 □ ID [brated		Thickness: Temp:	0.5"			
	PLA	TE F	PLATE		Ran	ıge: 0	.3" TO 1.0"		AMB ^o F			
Total Length Exam	88.6	<u>s" </u>		15"	Ref. Level Correction (Trans. Corr.): 0 DB							
	GEMA SVL	IT-INS-007.	3 .	Rev 2		erial Type: SS ⊠ CS O	THER:	Cond	ition: N/A			
File Name:	VERT.W	ALL/2 ND /PL	ATE 3 / 0			nsduc er: IDUAL ☐ SC	SL 🔯 0 DEG	ANGLE				
Xo Ref. Point (Lo): 1" BELOW HORIZONTAL WELD												
Yo Ref. Point (Wo): 17 INCHES FROM CENTER OF 1 ST . PASS												
Part # / Indication	X Start	X Stop	Y Start	Y Sto	ъP	Ave. Thk.	Min. Thk.,	Area	Max. Thk.			
0 - 12	(in)	(in)	(in)	(in)		(in) .509	R. Lig. (in) .488	Reportable	(in)			
12 - 24			 			.510	.488		,525 ,530			
24 - 36			 			.513	.491		.530			
36 - 48			<u> </u>			.514	.490		.530			
48 - 60		 	 			.515	.493		.530			
60 - 72				-		.513	.490		.530			
72 - 84			-			.512	.485		.530			
84 - 88.6			<u> </u>			.508	.490		.530			
	, ,						700		.525			
					· · · · · ·							
			<u> </u>									
			 									
				<u> </u>	•							
					-							
Remarks:			<u> </u>	<u> </u>		<u></u>		L				
Peak-Edge C	ontact Thic	kness Data	!									
					1				i			
Examiner: W.D. I	Purdy	Examiner:	yst: .	J. B. Elder	Revi	ewer: W. H. I	Nelson					
	voiri			$-\mid \frac{1}{\sqrt{2}}$	gon	and Mi	2/4	47/le	la_			
Level: <u>fl</u> Date: <u>(</u>	06/02/85	Date	:	Veve	el: <u>111</u>	Date: <u>7/4/05</u>	Leve	l: <u> </u> Date:_	7/17/05			
P-Scan Limited			·									
COGEMA-SVUT-INS-007	3 Rev 2 Attachn	nent 6						Rev	Dec 03 2003			

AUTOM	ATED ULT DATA	RASONI A REPOR		Job# 04	4-41	Riser # 25						
Location:	AST TANK	FARM		Exa	m Start: 04/18/05	0834	Exam End:	2138				
Component ID:	AN103	. / 11 \(\text{17} \)			mination Surfa	ce:	Nominal	0.75"				
Configuration:	PLA	TE TO	PLATE	Calibrated 0.3" TO 1.0" Temp:								
Total Length Exami			Scan Width:	15"	Ref. Level Correction (Trans. Corr.): 0 DB							
Procedure:	GEMA SVU		3		terial Type:	TUED:	Conc	lition:				
File Name:		WALL/2 ND /	····	2	Tra	SS ⊠ CS O' nsducer: DUAL □ SC		 G □ ANGLE	N/A °			
Xo Ref. Paint (Lo): 1" BELOW HORIZONTAL WELD												
Yo Ref. Point (Wo): 17 INCHES FROM CENTER OF 1ST. PASS												
Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)	op)	Ave. Thk. (in)	Min. Thk., R. Lig. (in)	Area Reportable	Max. Thk. (in)				
0 - 12						.757	.728		.777			
12 - 24						.758	.733		.77′3			
24 - 36	1					.756	.732		.771			
36 - 48						.757	.733		.774			
48 - 60						.756	.721		.772			
60 - 72						.756	.726		.772			
72 - 84						.755		.771				
84 - 96						.773						
96 - 104.6						.756	.726		.773			
			<u> </u>			ļ	<u> </u>	ļ				
		ļ										
			<u> </u>									
								ļ				
Romarka:		<u> </u>				1						
Remarks: Peak Contact Thickness Data												
	December 1		····		_/	·	97					
Examiner: W.D.	rdy	Examiner:		_ And	7	J. B. Elder	6 Rev	riewer: W.H.	Nelson			
Level: <u>II</u> Date: _	04/18/05	Dat	e:	. Løv	el: <u> II</u>	Date: <u>06/25</u>	i/05 Lev	el: <u> Date:</u>	7/17/05			
P-Scan Limited												

	ATED ULT	RASON REPOR			Job# O-	4-41	Riser # 25					
Location: 200 EA	AST TANK	FARM			Exa	m Start: 04/15/05	1039	Exam End:	2044			
Component ID:	AN103				mination Surfa	ce:	Nominal Thickness:	0.875"				
Configuration:	PLA	TE TO	PLATE	Cal	Calibrated Range: 0.3" TO 1.0" Thickness: 0.875							
Total Length Exam			Scan Width:		Level Correct		оп.):	o DB				
Procedure: COC	SEMA SVU		7.3	Ma	terial Type:	THER:	Cond	lition: N/A				
File Name:	VERT.\	NALL/2 ND	PLATE 5		Tra	I nsduce r:		3 🖂 ANGLE	0			
X _o Ref. Point (L _o): 1" BELOW HORIZONTAL WELD												
Yo Ref. Point (Wo):			CENTER (PASS	<u> </u>		· · · · · · · · · · · · · · · · · · ·				
Part # / Indication	X Start (in)	X Stop (in)	Y Start (in)	top	Ave. Thk.	Min. Thk., R. Lig. (in)	Area Reportable	Max, Thk. (in)				
0 - 12		, , , , , , , , , , , , , , , , , , ,	(0-7		·/	.882	,849	1,0,0,0,0	.900			
12 - 20.7						.885	.852		.900			
· · ·					······································							
								 				
							ļ					
						 		<u> </u>				
		 			·	<u> </u>			<u> </u>			
Remarks:	<u> </u>	<u> </u>				L	<u> </u>	<u> </u>				
Peak Contac	t Thickness	Data)						
Examiner: W. H.	Nelson	Examiner:		Ar	alyst:	J. B. Elder	// Re	viewer: W. H.	Nelson			
WHZU				J.C	mes (5)4	12 L	1421.	<u></u>				
Level: <u>III</u> Date: _	4/15/ 0 5	Da	ate:	_ Le	vei: <u>I</u>	Date: <u>6/25/</u>	<u>05</u> Lev	rel: III Date:	7/17/05			
COGEMA-SVUT-INS-007	7.3. Rev. 2. Attach	ment 6						Re	v. Dec. 03. 2003			

	AUTO		D ULTRA DATA REP		P-S	CAN		J	ob# O-	4-41	Ris	er# 2	5	
Loca				Syste			Exa	m	Start:		Exa	m End:		
		AST TA	NK FARM		F	PSP-4			04/11/05				2006	
	ponent ID:	AN103					⊠	Examination Surface:				ninal ckness:	0.5000)"
	iguration:		PLATE	PLAT	PLATE			nge	**	" TO 1.4 1		Temp:	AMB C	Ή̈́,
Tota	Length Exa	mined:	90,6"	Scan V	Scan Width: 15"			Ref. Level Correction (Trans, Corr): 0 DE						
Proc	edure: CC	GEMA	SVUT-INS-	007.3	Rev. Material Type: 3					THER:		Con	dition: N/A	
	Name	\/E	RT.WALL/	2 ND /OLAT	F 1				ducer:	3L 🖂 0 D		⊠ ANGL	E: 45 °	,
/ Iter	n#: lef. Point (Lo	٠	BOVE HOR			= D SC			UAL S	* 1100	:6	KI ANGL	<u> </u>	
Y _o F	tef. Point (W	٧).	ICHES FRO						······································					
	Sizing Meth		Angle (deg			nce Cal. S		Ī		Set-Up	/ File N	lame		
1			,g.c (3					+						
2								+		****				
3	AATT							T						
4	DUAL 0°							1				• • • • • • • • • • • • • • • • • • • •		
				INC	OICA	TION INF	ORMA	TIC	NC					
Ind.	Method	Weld			L1	Length			W1	Width	W2	Indi	cation Typ	De .
		Side	R. Lig.	Amp.	(in)	(in)	(in)	<u>}</u>	(in)	(in)	(in)			
		 	+ +				-							
		ļ	 			<u> </u>	-		 					
		ļ	<u> </u>											
		<u> </u>												
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		 	 			-	+		-			+		
Da	marks:	<u> </u>										1		
	lo Cracklik	ce Indica	rtions				_							
Exa	miner: W. I	H. Nelson	Examin	ier:		17	ynalyst:	J.	B. Elder	Re	viewe	r. W. H.	Nelson	
4	HMe	<u></u>	_			\	fen	42	BUC	- 1			Carry.	
Lev	el: <u>III</u> Date	: 04/11/0	5	Date:		- '	Čevel: _II	<u>!</u>	Date: <u>7/2/0</u>	<u>5</u> Le	vel: <u> 1</u>	Date:	zlali	2 5

COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 5

Rev. Dec. 03. 2003

	AUTO		D ULTRAS ATA REPO		CAN		Job# Riser# 25						
Loca		0 CT TAI	DZ EADM	System:	PSP-4	Exar	n Start:	0040	Exam Er				
Com	ponent ID:	451 IAI	NK FARM	<u> </u>	P3P-4	Fyai	04/12/05 mination Surf		Nominal	1444			
	•	AN103				⊠ ¢		PAINTED	Thicknes				
	figuration:		PLATE TO	PLATE		Ran	9 ***	0" то 1.41 "		^{np:} AMB ^O F			
Tota	Length Exam	nined:	89.3*	Scan Widti	^{n:} 15"			ction (Trans. (<u>0</u> DB			
Proc	edure: CC	GEMA S	SVUT-INS-00	7.3	Rev. 2		erial Type: SS 🖾 CS	OTHER:		Condition: N/A			
/ ite			RT.WALL/2 ^N	PLATE 2	2	Transducer: ☐ DUAL ☐ SGL ☐ 0 DEG ☒ ANGLE: 45°							
X _o F	Ref. Point (Lo)	1" BE	LOW HORIZ	ONTAL W	/ELD								
Y _o F	Yo Ref. Point (Wo): 17 INCHES FROM CENTER OF 1ST. PASS Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name												
	Sizing Meth	od	Angle (deg)	Refer	ence Cal. S	heet		Set-Up /	File Name				
1	45° SHEAR												
2	60° SHEAR			<u> </u>									
3	AATT						ļ						
4	DUAL 0°			111516			1						
		Weld	Depth Ma		TION INF	ORMAI	ION Wi	Width	W2 .				
Ind.	Method	Side	R. Lig. An		(in)	(in)	(in)	(in)	(in)	ndication Type			
						 							
ļ		ļ				-		 					
-													
 		1	 			+		 -					
1	marks: No Cracklik	e Indica	tions										
4	miner: W. f W. f vel: III Date:	<u></u>	Examiner:	Pate:		forme	J. B. Elder Bate: <u>07/0</u>	<u> </u>	viewer: W W21e vei: <u>III</u> Da	. H. Nelson 			

	AUTO		D ULTRA		P-S	CAN		Job#)4-41	Riser	# 25	
Loca	ition:		107 CADIA		tem:	200.4	Exan	n Start:	2224	Exam	-	2400
Cam	200 E.	ASIIA	NK FARM			PSP-4	Fyar	04/18/05 nination Surf		Nomi		2138
		AN103					Ø		PAINTED	Thick	ness:	0.5000"
	figuration:		PLATE	PLA			Rang	,	0" to 1.41"		Temp:	AMB ^o f
Tota	l Length Exa	mined:	89.7"	Scan	Scan Width: 15"			Ref. Level Correction (Trans. Corr): 0 DB				
Proc	cedure: CC	GEMA	SVUT-INS-	-007.3						Condit	ion: N/A	
	Name m #:	VE	ERT.WALL	/2 ND /PLA	TE 3			sducer:	SGL □ 0 DE	G ⊠	ANGLE:	45°
X _o F	Ref. Point (L _{o)}): 1" BI	ELOW HOP	RIZONT	AL W	ELD				· · · · · · · · · · · · · · · · · · ·		
Yo F	Ref. Point (W	o): 17 IN	NCHES FRO	OM CEN	NTER	OF 1ST.	PASS					
	Sizing Meth	od	Angle (deg	g)	Refere	nce Cal. She	et		Set-Up /	File Na	me	
1	45° SHEAR	ť									PLILAMATA	
2	60° SHEAR	t .										
3	AATT											
4	DUAL 0°											
				II.	IDICA	TION INFO	RMAT					
Ind.	Method	Weld Side	Depth R. Lig.	Max. Amp.	L1 (in)	Length (in)	L2 (ln)	(in)	Width (in)	W2 (in)	Indica	tion Type
		 	+			-						
		 	+		 	1			 			
		 	+ +			1	<u> </u>	 				
		 	1									
 		 	+			1		 	-			
-		+	+						 			F
	<u> </u>	┼──	++					+	<u> </u>		· · · · · ·	
-		 	+			-		 	 		<u> </u>	
<u> </u>		 	+						-			
┡	marks:	<u> </u>										
1	No Cracklik	e Indica	itions				1					
1	miner: W.E	Purdy	Examir	ner:		Arn	alyst: J	B. Elder	Re	viewer:	W. H. N 2 Je L	elson
i	/el: <u>II</u> Date: P-Scan Limited		$U_{\underline{\mathfrak{d}}}$	Date:		Le	vel: <u>] </u>	Date: _7/2/	25 Lev	/el: <u> </u>	Date: 7	117/05

	AUTO		D ULTRASO ATA REPO		CAN			4-41	Riser	25	
Loca		A 07 TAI	N/ EADA	System:	DCD 4	Exa	n Start:	22.5	Exam	End:	
Com	200 E.	ASI IAI	NK FARM		PSP-4	Eval	04/18/05 mination Surfa		Nomi	2142	
:		AN103				3	OD ID D		Thick	ness: 0.7500"	
	figuration:		PLATE TO	PLATE		Ran	ge:	0" to 2.12"	'	Temp: AMB OF	
Tota	l Length Exa	mined:	104.6"	Scan Width	¹¹ 15"		Ref. Level Correction (Trans. Corr):				
Proc	edure:	GEMA :	SVUT-INS-00	7.3	Rev. 2	Mate	Material Type: Condition: N/A				
File / Ite	Name m#:	VE	RT.WALL/2 ^{NI}	D/PLATE 4			sducer:	iGaL □ 0 DE	G 🗵	ANGLE: 45°	
	Ref. Point (L _{o)}	}·	LOW HORIZ						··		
Yo F	Ref. Point (W	·).	ICHES FROM	PASS							
	Sizing Meth		Angle (deg)		ence Cal. Sh			Set-Up /	File Na	me	
1	45° SHEAR		<u> </u>						· · · · · · · · · · · · · · · · · · ·		
2	60° SHEAR				·	···		- 			
3	AATT								······································		
4	DUAL 0°										
				INDICA	ATION INFO	RMAT	ION				
Ind.	Method	Weld Side	Depth Ме R. Lig. Ап		Length (in)	i.2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type	
		1									
		1							·		
	<u> </u>	1									
	marks: No Cracklik	e Indica	tions	<u> </u>		<i>a</i>		<u> </u>	_	<u> </u>	
Exe	aminer: W.). Purdy	Examiner:		2	alyst: .	J. B. Elder	Re	viewer:	W. H. Nelson	
1-	かかし	میں	<i>\f</i>	•	¥	evu	SOME	\sim μ	44	Jes-	
Lev	vel: <u>II</u> Date:	04/18/05	<u>.</u>	ate:	Ĺe	vet: <u>.111</u>	Date: <u>07/0</u>	4/05 Lev	vet: <u>III</u>	Date: 7(17/05	
1 F	Scan Limited	j						-		. •	

	AUTO		D ULTRASO ATA REPO		CAN)4-41	Riser#	25		
Loca				System:	DOD 4	Exa	n Start:		Exam En	- 1		
		AST TAN	NK FARM	<u> </u>	PSP-4	ļ	04/15/05 nination Sur		NI	2040		
	ponent ID:	AN103	+			⊠ (ן פום סכ	PAINTED	Nominal Thicknes			
	iguration:		PLATE TO	PLATE		Ran	9	0" to 2.47				
Tota	Length Exan	nined:	20.7"	Scan Widt	n: 15"			ction (Trans.	•	<u>0</u> DB		
Proc	edure: CO	GEMA S	SVUT-INS-00	7.3	Rev. 2	Mate	erial Type: SS ⊠ CS	OTHER:	°	ondition: N/A		
File I	Name n #:	VE	RT.WALL/2nd	d/PLATE	5		sducer: DUAL []:	SGL □ 0 DI	EG ⊠AN	KBLE: <u>45</u> °		
X₀ R	tef. Point (L _o):	1" BE	LOW HORIZ	ONTAL W	ÆLD		· · · · · · · · · · · · · · · · · · ·					
Y _o R	Yo Ref. Point (Wo): 17 INCHES FROM CENTER OF 1ST. PASS											
	1/ INCHES FROM CENTER OF 1ST. PASS Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name											
1	45° SHEAR											
2	60° SHEAR											
3	AATT											
4	DUAL 0°											
				INDICA	TION INFO	RMAT	ION					
Ind.	Method	Weld	Depth Ma		Length	L2	W1	Width	W2 ₁	ndication Type		
-	.,,,,,,,,,	Side	R. Lig. Am	ip. (in)	(in)	(in)	(in)	(in)	(in) "			
	·····											
		:					ĺ					
							- -		-			
	·····				1			1				
			 					 		- 		
			 									
	<u></u>	<u> </u>	 					 				
			<u> </u>					<u> </u>				
1	marks: lo Cracklike	e Indicat	ions			0						
Exa	miner: W. H	. Nelson	Examiner:		A ₇	ályst: .	J. B. Elder	/ Re	viewer. W.	H. Nelson		
1	WADet Jamos Elle WADer											
rev	er <u>IN</u> Date:	-# 13/03	- "	ate:	_ Le	ver, <u>) </u>	Date: <u>06/</u> 2	Le	vel. <u>III.</u> Dai	a Altino		

AUTOMA		RASONIC	THICKNE T	ESS			1-41	Riser# 25	5			
Location: 200 F/	AST TANK	FARM			Еха	m Start: 06/02/05	0856	Exam End:	1921			
Component ID:	AN103	7 4 4171				mination Surfa	ce:	Nominal	0.5"			
Configuration:	PLA	TE TO D	LATE		Call	⊠ OD □ ID □ ibrated	3" TO 1.0"	Thickness: Temp:	AMB ^O F			
Total Length Exami			can Width:	4 770)	Ref. Level Correction (Trans. Corr.):							
Procedure:	120"		<u>a</u>	17" ev	Mai	teriai Type:		Cond	O DB			
CO	SEMA SVU	T-INS-007.	3 , "	2		SS ⊠ CS O	HER:		N/A			
File Name:	L	IQUID/AIR-	-1			nsducer: IDUAL ☐ SG	L Ø O DEC	S ANGLE	0			
Xo Ref. Point (Lo):	EAST OF	24" RISER	, @ EAST	AIR LIN	E							
Yo Ref. Point (Wo): 20" FROM CL OF WELD TO CL OF SCANNER												
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk. (in) (in) (in) (in) R. Lig. (in) Reportable (in)												
0 - 12 (in) (in) (in) (in) (in) (in) R. Lig. (in) Reportable												
12 - 24						.554	.528		.565			
24 - 36						.552	.528		.565			
36 - 48						.551	.521		.565			
48 - 60						.552	.523		.565			
60 - 72						.550	.52 0		.565			
72 - 84						.548	.524		.565			
84 - 96					.548 .517 .56							
96 - 108						.548	.521		.560			
108 - 120						.548	.518		.560			
Remarks: Peak Contac	Remarks: Peak Contact Thickness Data											
WATU	Examiner: W. H. Nelson											
COGEMA-SVUT-INS-007					J., J.			-	v. Dec. 03, 2003			

AUTOMA		RASONIO REPOR	C THICKNE T	ESS			1-41	Riser# 2	5			
Location: 200 EA	ST TANK	FARM				m Start: 06/02/05		Exam End:	1921			
Component ID:	AN103					mination Surface ☑ OD ☐ ID ☐		Nominal Thickness:	0.5*			
Configuration:	PLA1	re ^{to} F	LATE			brated o	.3" to 1.0"	Temp:	AMB °F			
Total Length Exami	ned: 120°	S	ican Width:	17"	Ref. Level Correction (Trans. Corr.):							
Procedure: COC	SEMA SVU	T-INS-007	.3 R	ev 2		erial Type: SS ⊠ CS 01	THER:	Cond	tition: N/A			
File Name:	LI	QUID/AIR-	1A			nsducer. IDUAL ∐SG	EL 🔯 O DEC	E □ ANGLE	. 0			
Xo Ref. Point (Lo):	END OF F	PREVIOUS	FILE				23 7 7 2					
Yo Ref. Point (Wo): 20" FROM CL OF WELD TO CL OF SCANNER												
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk. (in) (in) (in) (in) R. Lig. (in) Reportable (in)												
0-12 .549 .516 .565												
12 - 24 .549 .524 .565												
24 - 36						.549	.523		.565			
36 - 48						,549	.510		.565			
48 - 60						.549	.523		.565			
60 - 72						.548	.470		.565			
72 - 84						.547	.519		.565			
84 - 96					548 .518 .5				.565			
96 - 108						,541	.515		.565			
108 - 120						.541	.516		.560			
·												
Remarks:	<u> </u>	J	<u> </u>	<u></u>		<u> </u>	L	<u> </u>	<u></u>			
Remarks: Peak Contact Thickness Data												
Examiner: W. H.	Examiner: W. H. Nelson Examiner: Analyst: J. B. Elder											
WHITE			· · · · · · · · · · · · · · · · · · ·	_ \	en	es B We	- W	1DTo	<u></u>			
Level: III_ Date: _	06/02/05	Date	<u> </u>	Les	/el: <u> </u>	<u> Date: _7/4/0</u>	5 Lev	el: <u>III</u> Date:	z n is			
COGEMA-SVUT-INS-007	3 Rev 2 Attachi	ment 6						C.	ev. Dec, 03, 2003			

AUTOMA	ATED ULT DATA	RASON REPOR		NESS			4-41	Riser# 25	5			
Location: 200 F/	AST TANK	FARM			Exa	m Start: 04/18/05	0922	Exam End:	2130			
Component ID:	AN103			· · · · · · ·		mination Surfa	ce:	Nominal	0.5*			
Configuration:	PLAT	TO TO	PLATE		Cali	⊠OD □ID □ brated	.3" TO 1.0"	Thickness: Temp:	AMB °F			
Total Length Exami	nad.	Т	Scan Width:	45 478	Ran Ref.	ge: Level Correcti		30E).				
Procedure:	120"			15-17" Rev	Mat	erial Type:		Cond	0 DB			
COC	SEMA SVU	T-INS-00	7.3	2		SS X CS O	THER:		N/A			
File Name:		LIQUID/A	IR			n sducer:]DUAL ☐ SC	SL 🛛 O DEC	3 ANGLE	. 0			
X _o Ref. Point (L _o):	EAST OF	24" RISE	R, @ EAS	T AIR LIN	E							
Yo Ref. Point (Wo): 31" FROM CL OF WELD TO CL OF SCANNER												
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk. (in) (in) (in) (in) Reportable (in)												
	(in)	(in)	(ln)	(in)	 		Reportable				
0-12						.543	.505		.550			
12 - 24						.543	.518		.550			
24 - 36			- 			.545	.519		.550			
36 - 48			_			.543	.519		.550			
48 - 60						.542	.514		.550			
60 - 72						.543	.476		.550			
72 - 84						.541	.485	ļ	.550			
84 - 96						,539	.511		.550			
96 - 108						.538	.509		.550			
108 - 120						.538	.508		.550			
	<u> </u>						ļ	-				
												
		<u> </u>							1			
	<u> </u>					<u> </u>		<u> </u>				
Remarks: Peak Contac	t Thickness	Data		<u> </u>		<u> </u>			<u> </u>			
					1							
Examiner: W. H.	Examiner: W. H. Nelson Examiner: Analyst: J. B. Edger Reviewer: W. H. Nelson WATELL Company The Company Comp											
Level: <u>/ii</u> Date: _	04/18/05	Da	ate:	_ /e	vel: <u> </u>	Date: 7/2/0	5 Lev	el: <u>III</u> Date:	7/17/05			
COGEMA-SVUT-INS-007	3 Rev. 2. Attachi	nent 6						Re	rv. Dec. 03, 2003			

AUTOM	ATED ULT DATA	RASONIC REPORT		NESS		# dot # 04	1-41	Riser # 25	5			
Location:	AST TANK	EADM			Exa	m Start:	0022	Exam End:	2420			
Component ID:		-WL/MI			Exa	04/18/05 mination Surface	0922 □e:	Nominal	2130			
	AN103	10 _				⊠ OD □ ID [ibrated		Thickness: Temp:	0.5"			
Configuration:	PLA7	E P	LATE		Rar	nge: U.	.3" TO 1.0"		AMB [○] F			
Total Length Exam	ined: 120"	S	an Width:	17"	Ref	. Level Correcti	on (Trans. Co)гт.): _	O DB			
Procedure: CO	GEMA SVU	T-INS-007.	3	Rev 2		terial Type: ISS ⊠CS O⊺	HER:	Cond	Ition: N/A			
File Name:	L	QUID/AIR	A			nsducer:]DUAL ☐ SG	SL 🖾 O DEG	ANGLE	. 0			
X _o Ref. Point (L _o): END OF PREVIOUS SCAN												
Yo Ref. Point (Wo): 31" FROM CL OF WELD TO CL OF SCANNER												
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max: Thk.												
0 - 12	(in)	(in)	(in)	(in)	(in) .538	.505	Reportable	(in) .550			
12 - 24						.538	.508		.550			
24 - 36		<u></u>	1			.538	.514		.550			
36 - 48						.540	.511		.550			
48 - 60			<u> </u>			.539	.505		.550			
60 - 72						.539	.509		.550			
72 - 84						.538	.508	<u> </u>	.550			
84 - 96			<u> </u>		.537 .508				.550			
96 - 108						.537	.508		.550			
108 - 120						.532	.506					
100-120			 			.002	.006		.550			
			 									
					~~~	ļ						
<u> </u>												
	 					<u> </u>		 				
Remarks:	1	<u> </u>	1			1	<u> </u>	1				
Remarks: Peak Contact Thickness Data												
Examiner: W. H.	Examiner: W. H. Nelson Examiner: Analyst: J. B. Eider Reviewer: W. H. Nelson											
Level: []] Date:	04/18/05	Date		_ Lev	/el: <u>][</u>	Date: 7/2/0	5 Lev	el: III Date:	7/17/05			
COGEMA-SVUT-INS-007	7.3. Rev. 2. Attachr	nent 6						Re	v. Dec. 03, 2003			

AUTOMA	TED ULT DATA	RASONIC REPOR		NESS	Job# Riser# 25				5		
Location: 200 EA	ST TANK I	FARM			Exa	m Start: 05/09/05	1330	Exam End:	1934		
Component ID:	AN103			<u> </u>		mination Surfa	ce:	Nominal Thickness:	0.5"		
Configuration:	PLAT	E TO	PLATE		Cal	broted	.3" TO 1.0"	Tome	AMB ^O F		
Total Length Exami	ned: 88.6'	. 5	Scan Width:	11.8"	Ref	Ref. Level Correction (Trans. Corr.): O DB					
Procedure: COG	SEMA SVU	T-INS-007	.3	Rev 2	Ma	terial Type:	THER:	Cond	lition: N/A		
File Name:	VERT	.WELD /PI	LATE 2		Tra	nsducer:		G [] ANGL	0		
Xo Ref. Point (Lo):	1" BELOW			LD	<u>r-</u>						
Yo Ref. Point (Wo):	Yo Ref. Point (Wo): CENTERLINE OF WELD										
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk. (in) (in) (in) (in) R. Lig. (in) Reportable (in)											
0 - 12	(m)	(41)	1 (111)	(31)	,	.510	.486	Reportable	.535		
12 - 24			1			.514	.498		.535		
24 - 36						.515	.491		.535		
36 - 48						.517	.491		.535		
48 - 60						.515	.485		.540		
60 - 72						.516	.500		.535		
72 - 84						.516	.499		.535		
84 - 88.8					.517 .454				.540		
			1			<u> </u>					
						<u> </u>					
						ļ					
						 					
		1		_		<u> </u>					
						1					
Remarks:		L				1	<u> </u>		<u> </u>		
Peak-Edge C	ontact Thic	kness Dat	a								
Examiner: W. Q.	Purdy.	Examiner;		l AA	Alved:	J. B. Eltief //		viewer, W. H.	Nolenn		
Man	when			🗘	ar	ws58le	_ 2	110 De	<u></u>		
Level: Date: _	05/09/05 U	Dat	e:	_ Le	/el: _∐	Date: 06/30	2/05 Le	vel: III Date:	वितर		
P-Scan Limited COGEMA-SVUT-INS-007					·			 	v. Dec. 03. 2003		

AUTOMA	ATED ULT	RASONI A REPOR		NESS		Job#	4-41	Riser #	5			
Location: 200 EA	AST TANK	FARM			Exa	m Start: 05/18/05	0915	Exam End:	2047			
Component ID:	AN103					mination Surfa		Nominal Thickness:	0.5"			
Configuration:	PLA.	re TO	PLATE		Cal	ihrated	.3" TO 1.0"	1 11	AMB ^o F			
Total Length Exami	ined: 88.9	Ħ	Scan Width:	11.9"		Level Correcti	on (Trans. Co	эт.):	o DB			
Procedure; COC	GEMA SVU	T-INS-007	'.3	Rev 2		Material Type: Condition: ☐ SS ☑ CS OTHER: N/A						
File Name:	VERT	.WELD /P	LATE 3	<u> </u>	Tra	nsducer:		ANGLE	0			
Xo Ref. Point (Lo):		V HORIZO		ELD	, <u></u>		<u> </u>		···			
Yo Ref. Point (Wo): CENTERLINE OF WELD												
Part # / Indication X Start (in) X Stop (in) Y Start (in) X Stop (in) X Start (in) X Stop (in) X Start (in) X Stop (in) X												
0 - 12						.505			.530			
12 - 24						.509	.474		.530			
24 - 36						.505	.462		.530			
36 - 48						.510	.470		.530			
48 - 60						.500	.455		.530			
60 - 72						.501	.458		.530			
72 - 84		<u></u>				.502	.459		.530			
84 - 88.9		ļ <u>.</u>			.505 .460				.525			
		ļ										
								 				
			-									
		1						1				
Remarks:	<u> </u>	J				<u> </u>	1	1	<u> </u>			
Remarks: Peak-Edge Contact Thickness Data												
Examiner: W.O.	Examiner: W.D. Purdy Examiner: Analyst: J. B. Elder Reviewer: W. H. Nelson											
Level: <u>Il</u> Date: _	05/18/05	Da	te:	_ Le	/el: <u> </u>	Date: 06/30)/05 Lev	el: <u> </u>	7/17/05			
P-Scan Limited	7.2 Pour 2. Attack	mont 6							v Oec 83 2003			

AUTOMA	ATED ULT	RASON REPO		NESS		Job# O4	1-41	Ris	er# 25		
Location:					Exa	m Start:		Exa	m End:		
	AST TANK	FARM			<u> </u>	05/12/05	0921	<u> </u>		1442	
	AN103					mination Surface			ninal ckness:	0.75*	
Configuration:	PLA	TE TO	PLATE		Rai	Calibrated Range: 0.3" To 1.0" Temp: AMB O					
Total Length Exami	ined: 102.	8"	Scan Width:	11.5"		Ref. Level Correction (Trans. Corr.):					
Procedure: COC	BEMA SVU	T-INS-00	7.3	Rev 2		terial Type:]ss ⊠cs of	THER:	_	Cond	ition: N/A	
File Name:	VERT	:WELD /I	PLATE 4		I nsducer: ☑DUAL ☐ SO	SL Ø10DE	G	☐ ANGLE	. 0		
Xo Ref. Point (Lo):	1" BELOV	V HORIZ	ONTAL WE	LD	.2						
Yo Ref. Point (Wo): CENTERLINE OF WELD											
Part # / Indication X Start (in) X Start (in)											
0-12				ŀ		.756	.708			.775	
12 - 24						.752	.733			.775	
24 - 36						.752	.731			.775	
36 - 48						.750	.718			.775	
48 - 60						.753	.731			.775	
60 - 72						.752	.727			.775	
72 - 84						.752	.730		,	.775	
84 - 96						.755	.719			.775	
96 - 102.8						.756	.738			.775	
		 						-			
		 						-			
		1						+			
						1		+			
Remarks:	L	1		<u> </u>		.1.	<u> </u>			<u> </u>	
Peak-Edge C	Contact Thic	ckness Da	ata		<i>^</i>						
Examiner: W. H. Nelson Examiner: Analyst: J. B. Edder// Review									er. W. H.	Nelson	
WHYDU	<u></u>				Janos Ode women						
Level: <u>III</u> Date:	05/12/05	D	ate:	_ (e	vel: <u>l</u>	ll Date: <u>6/30/</u>	05Le	vel: <u>1</u>	II Date:	تطحالة	

Rev. Dec. 03, 2003

COGEMA-SVUT-INS-007.3. Rev. 2. Attachment 6

AUTOMA		RASON A REPO	IIC THICK RT	NESS	Job# Riser# 25				;		
Location: 200 EA	ST TANK	FARM			Exa	am Start: 05/16/05	0935	Exa	ım End:	1355	
Component ID:	AN103					amination Surfa ☑ OD ☐ ID [Ce:	No	minal ckness:	0.875*	
Configuration:	PLA	TE TO	PLATE		Cal	librated o	.3" TO 1.		1	AMB °F	
Total Length Exami			Scan Width:	11.4"	Re	Ref. Level Correction (Trans. Corr.): ODB					
Procedure:	SEMA SVU		17 3	Rev 2	Material Type: Condition:					ition:	
File Name:		r.WELD/			Tra	insducer:				N/A °	
Xo Ref. Point (Lo):				:1 P)		DUAL S	3L 🔯 01	DEG	ANGLE		
Yo Ref. Point (Wo):				<u></u>		<u> </u>	- v		· Laner - in		
1" BELOW HORIZONTAL WELD 1" BELOW HORIZONTAL WELD Yo Ref. Point (Wo): CENTERLINE OF WELD											
0-12						.875					
12 - 21.2						.875	.850			.900	
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		<u> </u>				<u> </u>					
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		<u> </u>				<u> </u>		+			
							<u> </u>				
						<u> </u>					
1	Remarks: Peak-Edge Contact Thickness Data										
Examiner: DV D.	Purdy	Examiner.		Ar	alyst:	J. B. Elder	7	Review	BF: W. H.	Nelson	
MAM	types			_	YA	MA (Law		W+	Llee		
Level: <u>II</u> Date: _	05/16/05	ם)ate:	_ Lé	vel: _	II Date: 6/30/	<u>105</u> 1	.evel: _l	II Date:	1/13/02	
P-Scan Limited)			- [

	AUTO		D ULTRA		P-S	CAN		Job#)4-41	Rise	er# 25	>	
Loca	ition;				stem:	DOD 4	Exar	n Start:		Exa	m End:	40.4	
-		ASITA	NK FARM	l		PSP-4	Eva	05/09/05 nination Surf		Non	ninal	1945	
	ponent ID:	AN103					⊠ (OI □ OC	J PAINTED		kness:	0.5000"	
	figuration:		PLATE '		ATE	<u></u> .	Ran		0" to 1.5"		Temp:	AMB °F	
	I Length Exa	mined:	86.4*	Scar	n Width	9.9			tion (Trans.	Соп):	<u>.c</u>	<u>8</u>	
Proc	edure: CC	GEMA	SVUT-INS	-007.3		Rev. 2	Mate	erial Type: SS 🖾 CS	OTHER:		Cond	lition: N/A	
	Name	·	/ERT.WEL	DPLAT	F 2			sducer: DUAL ⊠	ec	EC.	EZ ANICH E	: <u>60</u> °	
/ Ite	m#: Ref. Point (L _o)		LOW HO		············	EI D	L,_ <u>L</u>	DUAL 🔯	sgL □0D	<u> </u>	M ANGLE		
Yof	Ref. Point (W	2.	TERLINE (
 	Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name												
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR 2 60° SHEAR													
					····-				~				
3	AATT				· · · · · · · · · · · · · · · · · · ·					· · · · · ·			
4	DUAL 0°												
				11	NDICA	TION INF	ORMAT	ION					
ind.	Method	Weld Side	Depth R. Lig.	Max. Amp.	L1 (in)	Length (in)	L2 (in)	VV1 (In)	Width (in)	W2 (in)	indic	ation Type	
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-		<u> </u>	 				╁		 -		 		
BA	marks:	<u></u>						L					
j	NO CRACKLIKE INDICATIONS												
Exi	Examiner W. D. Purdy Examiner: Analyst/ J. B. Elder Reviewer: W. H. Nelson												
Lev	/el: <u>J)</u> Date:	05/09/0	5	Date:		_	/	Date: <u>07/</u> (_ Date:]	Inlos	

	AUTO		ULTRAS TA REPO	RT	SCAN)4-41	Rise	25	
Loca		AST TANK	FARM	System:	PSP-4	Exar	n Start: 05/18/05	0035	Exa	m End: 2057	
Com	ponent ID:		LAMIN	<u> </u>	F 01-4		nination Surf	ace:		ninal 0 5000	
Conf	Iguration:	AN103	то				DD ID I			kness; 0.5000"	
			ATE	PLATE		Ran	ge:	0" to 1.5"	t	AMB OF	
Tota	l Length Exar	nined: 86	5.5"	Scan Widti	h: 10"			tion (Trans.	Corr):	0 DB	
Proc	edure: CO	GEMA SV	UT-INS-00	7.3	Rev. 2	Mate	eriai Type: SS ⊠ CS (OTHER:		Condition: N/A	
File / Iter	Name	VEI	RT.WELD	PLATE 3			sducer: DUAL 🔯 9	GL []0D	FG I	⊠ ANGLE: <u>60</u> °	
	Ref. Point (L _o)		OW HORIZ		ÆID		DOIL 23			<u> </u>	
Yo F	Ref. Point (Wo				, , , , , , , , , , , , , , , , , , ,						
\vdash	Sizing Metho		Angle (deg)		ence Cal. S	heet		Set-Up	/ File N	lame	
1 45° SHEAR											
2	60° SHEAR										
3	AATT										
4											
L					ATION INF						
Ind.	Method		Depth Ma R. Lig. An		Length (in)	1.2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type	
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		<u> </u>						<u> </u>			
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 		 -						 			
1	Remarks: NO CRACKLIKE INDICATIONS										
Exa	xaminer, W. D. Purdy Examiner: Analyst: J. B. Elder Reviewer: W. H. Nelson										
ىدا	フカナグ	<u>Lylar</u>				your	25 KK	2 6	UD	Ze_	
Lev	el: <u>II</u> Date:	05/18/05		ate:	1	_evel: <u> </u>	Date: <u>07/0</u>	6/05 Le	vel: <u>III</u>	Date: 7 17 05	
F	-Scan Limited	ı								• •	

	AUTO		D ULTR			CAN		# doL	04-41	Ris	er# 25
Loca					System:	200.4	Exa	m Start:			em End:
		AST TAI	NK FARN		F	PSP-4	-	05/12/			1440
	ponent ID:	AN103		-	·····		⊠		PAINTI		minal ickness: 0.7500"
	figuration:		PLATE		PLATE	· · · · · · · · · · · · · · · · · · ·	Rar		0° то 3		Temp: AMB OF
	l Length Exal	กined:	100.4"		ican Width:	8.4"			rrection (Tra	ns. Corr):	<u>n</u> DB
		GEMA :	SVUT-INS	-007.	3	Rev. 2			OTHER:		Condition: N/A
File / Iter	Name n #:	V	ERT.WE	LD PL	ATE 4			nsducer:] DUAL	⊠isgl □	0 DEG	⊠ ANGLE: 60°
X ₀ F	tef. Point (Lo)	1" BE	LOW HO	RIZO	NTAL WE	LD					
Y _o F	Ref. Point (Wo	EN CEN	TERLINE	OF W	ÆLD				······································		
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR											
1	45° SHEAR										
2	60° SHEAR										
3	AATT										
4	DUAL 0°										
	INDICATION I							TION			
ind.	Method	Weld Side	Depth R. Lig.	Max. Amp.	L1 (in)	Length (in)	(in)			W2 (in)	Indication Type
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		<u> </u>	<u> </u>							<u> </u>	
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L		<u>]</u>			<u> </u>						
1	Remarks: NO CRACKLIKE INDICATIONS										
Exa	aminer: W. I V D 200	i. Nelson	Exam	iner:			1.	J. B. Elder		Reviewe	er: W. H. Nelson
WHTU										11 Date: 7/17/05	

	AUTC		D ULTRAS ATA REPO		CAN)4-41	Riser#	25
Loca		AST TAI	NK FARM	System:	PSP-4	Exa	m Start: 05/16/05	0053	Exam	End: 1405
Com	ponent ID:				F-0F-4		mination Surf	ace:	Nomin	al
Conf	iguration:	AN103	то	· · · · · · · · · · · · · · · · · · ·			OD □ ID [brated	······································	Thicien	
			PLATE "	PLATE		Ran	ge:	0" то 3.5"		AMB OF
	Length Exar	nined:	19.2"	Scan Width	n: 8,4"			tion (Trans. (Corr): 	<u>0</u> DB
Proc	edure: CO	GEMA (SVUT-INS-0	07.3	Rev. 2		erial Type: SS 🖾 CS (OTHER:		Condition: N/A
File / Iter	Name n#	V	ERT.WELD	PLATE 5	<u> </u>		nsducer:	SGL □ 0 DE	-G 13	ANGLE: <u>60</u> °
	lef. Point (Lo)	١٠	LOW HORIZ		/ELD					
Yo F	Ref. Point (Wo	-).	TERLINE OF					······································		
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name										
1	45° SHEAR									
2	60° SHEAR	,								
3	AATT						ļ			
4	DUAL 0°									
		101-14	1 n46 1/4		ATION INFO	,		1 145 41		4 4
ind.	Method	Weld Side	1 ! 1	lax. L1 mp. (in)	Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type
		<u> </u>	<u> </u>				1	<u> </u>		
		<u> </u>	<u> </u>			ļ				
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	···	<u> </u>	<u> </u>							
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						<u> </u>		<u> </u>		
	!									
	<u> </u>		1							
1	Remarks: NO CRACKLIKE INDICATIONS									
Exa	aminer W. D. Purdy Examiner: Analyst: J. 8. Edge Reviewer, W. H. Nelson									
77	<u> ५७८८</u> ८	بيلمد	<u> </u>	···		10n	10) () (V	L 14	1 40- 7	Jee-
Lev	rel: <u>li</u> Date:	05/16/05	<u>}</u>	Date:	_	vel: <u> </u>	Date: _ <u>7/6/</u>	05 Lev	vel: <u> </u>	Date: 7(17/0)

	AUTO		ULTRAS TA REPO	ONIC P-S RT	CAN)4-41	Riser#	25	
Loca		ST TANK	FARM	System:	PSP-4	Exen	n Start: 05/26/05	0808	Exam 8	nd: 2025	
Com	ponent ID:	AN103	CIPUM				nination Surf	ace;	Nomina		
Conf	iguration:		TO				D □ ID [Prated		Thickne		
	Length Exam	nined:	ATE	PLATE Scan Width		Rang	,	0" TO 1.41"		AMB OF	
		90).3"		5.6"			(11010)		0 DB Condition:	
		GEMA SV	UT-INS-00	7.3	Rev. 2			OTHER:		N/A	
File /	Name n#:	VERT	.WELD/2 ^N	P/ PLATE 2			sducer: DUAL ⊠S	GL 0 DE	:G ⊠.	ANGLE: 45°	
X ₀ F	ef. Point (Lo)	1" BEL	OW HORIZ	ONTAL W	ELD						
Yo F	Yo Ref. Point (Wo): CENTERLINE OF WELD Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name										
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR											
 							ļ				
2	60° SHEAR							· · · · · · · · · · · · · · · · · · ·			
3	DUAL 0°			1							
4	DUAL U			INDICA.	TION INE	ORMAT	ION				
INDICATION INFORMATION Weld Depth Max. L1 Length L2 W1 Width W2											
ina.	Method	Side	R. Lig. An	np. (in)	(în)	(in)	(in)	(in)	(h)	indication type	
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Ps	marks:	<u> </u>				<u></u>		<u> </u>			
		LIKE INDI	CATIONS								
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Exa	xaminer: W. D. Purdy Examiner: Analyst: J. B. Elder (1) Reviewer: W. H. Nelson										
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Lev	el: <u>II</u> Date:	05/26/05))ate:	_	• evel: <u> </u>	Date: 6/27	<u>7/05</u> Le	vel: <u> </u> [Date: 7 17 05	
	-Scan Limited										

	AUTO		D ULTR			CAN		Job#)4-41	Rise	er# 25
Loca		ACT TAI	UZ EADA		System:	DOD 4	Exan	n Start:	2000	Exa	ım End:
Com	200 E/	ASI IAI	NK FARM	n		PSP-4	Evan	05/26/05 nination Sur		Nor	2025 ninal
	•	AN103					⊠c	OI OC	PAINTED		ckness: 0.5000"
	iguration:	 	PLATE		PLATE		Rang	y	0" to 1.41		Temp: AMB °F
	l Length Exa	mined:	87.8"		Scan Width	5.6"			ction (Trans.	Corr):	<u>0</u> DB
Proc	edure: CC	GEMA S	SVUT-IN	s-007	.3	Rev. 2	Mate	rial Type: SS ⊠CS	OTHER:		Condition: N/A
File / Iter	Name n #:	VE	RT.WELC)/2 ND /	PLATE:	3		sducer: DUAL 🔯 :	SGL 🔲 0 D	EG	⊠ ANGLE: 45°
X ₀ F	Ref. Point (L _o)): 1" BE	LOW HO	RIZO	NTAL W	ELD					
Yo Ref. Point (Wo): CENTERLINE OF WELD Sizing Method Angle (deg) Reference Cal. Sheet Set-Ho / File Name											
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR											
1	45° SHEAR										
2	60° SHEAR										
3	AATT								.		
4	DUAL 0°		······································					<u> </u>			
ļ,			1		INDICA			T		<u></u>	
Ind.	Method	Weld Side	Depth R. Lig.	Max. Amp		Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type
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Re	marks:	<u></u>							·J		
١	IO CRACK	CLIKE IN	DICATIO	NS							
1											
Exa	kaminer: W. D. Purdy Examiner: Analyst: J. B. Elder // Reviewer: W. H. Nelson										
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	rel: li Date:	(\mathcal{Z}	Post	۵٬	7	wet III	Date: Six	705	val: I	Date: 7 17 05
	-Scan Limited		-	L/d\	e:	"	57 6 1. <u>[]]</u>	Date: <u>6/27</u>	Te	vei. <u>II</u>	L nate: TITUS
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AUTOMA	TED ULTRAS DATA REPO			Job# O4	4-41	Riser#	5					
Location:		System:	Exan	n Start:		Exam End:						
	TANK FARM	PSP-4	\$ <u> </u>	05/26/05	8080		2025					
	103		⊠c	nination Surfac		Nominal Thickness:	0.7500"					
Configuration:	PLATE TO	PLATE	Calib Rang	orated ge: 0	то 2.12 "	Temp:	AMB °F					
Total Length Examined	^E 87.8"	Scan Width: 5.	.6" Ref.	Level Correcti	on (Trans. C	Corr):	80 <u>0</u>					
Procedure: COGE	MA SVUT-INS-00	7.3 Rev.		eriaiType: SS ⊠CS O1	THER:	Cone	dition: N/A					
File Name / Item #:	VERT.WELD/2N	P/ PLATE 4		sducer: DUAL ⊠SG	3L □ 0 DE	G ⊠ ANGLI	<u> 45</u> °					
Xo Ref. Point (Lo): 1	BELOW HORIZ	ONTAL WELD										
Yo Ref. Point (Wo): C	CENTERLINE OF WELD											
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name												
1 45° SHEAR												
2 60° SHEAR					······································							
3 AATT												
4 DUAL 0°												
		INDICATION										
I had a ballan i	eid Depth Ma de R. Lig. An		ngth L2 n) (in)	(in)		(in) indic	cation Type					
<u> </u>				_								
Remarks:												
NO CRACKLIK	E INDICATIONS											
Examiner: \W.D. Pur	dy Examiner		Aplaiyst: J	I. B. Elder	Rev	riewer: W. H.	Nelson					
MDHY	dy		Jan	235588E	2/2	UDDJe						
Level: <u>II</u> Date: <u>05/</u>	26/05	ate:	Level: 111	Date: <u>6/27/</u> 0	05 Lev	rel: III Date:	योगिव					
P-Scan Limited	<u> </u>]									
COGEMA-SVUT-INS-007.3.	Rev. 2. Attachment 5					Re	v. Dec. 03. 2003					

	AUTO		ULTRASO ATA REPO		SCAN			04-41	Rise	r# 25			
Loca	ition:	ACT TAN	Y EADM	System:	PSP-4	Exar	n Start:	^^^E	Ехаг	m End:			
Con	200 E/	AST TAN	A FAIRINI	<u>.L</u>	P3F-4	Exar	05/27/05 mination Surf		Nom	1400 inal			
		AN103	ТО			図(DD ID [kness: 0.875"			
	figuration:		LATE	PLATE		Rang	ge:	0" to 2.47"		AMB OF			
	l Length Exar	nined: 2	?1. 4"	Scan Width	5.9"	ľ		ation (Trans. C	corr):	<u>0</u> DB			
		GEMA S	VUT-INS-00	17.3	Rev. 2		erial Type; SS ⊠ CS (OTHER:	=	Condition: N/A			
File / Iter	Name m #:	VER	T.WELD/2 ^{NI})/ PLATE	5		ISCUCET: DUAL ⊠S	SGL 0DE	G [MANGLE: 45°			
	Ref. Point (L _o)	<u>}:</u>	OW HORIZ			1 2000							
Yo F	Ref. Point (Wo	٧).	<u> </u>		/ [
	CENTERLINE OF WELD Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name												
ļ.,													
							1						
						A	-						
4	DUAL 0°								····				
				INDIC/	ATION INFO	RMAT	TON						
Ind.	Method	Weld Side	Depth Ma R. Lig. Arr		Length (in)	L2 (in)	W1		W2	Indication Type			
	<u> </u>	Situe	K. Lig. Air	1 p. (111)	- (0)	(81)	(in)	(in)	(ln)	 			
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ŧ		CLIKE INC	DICATIONS										
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Ex	aminer: \W.) Purdy	Examiner:		TA	nalvst:	J. B. Eider) Rev	nje MBL	: W. H. Nefson			
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1	/el: <u> </u>		<u> </u>)ate:	Le	:vel: <u> </u>	Date: <u>07/0</u>	16/05 Lev	/et: <u> </u>	Date: 7/17/05			
F	Scan Limited	đ						1					

AUTOMA		RASONIC REPORT		ESS			1-41	Riser#	5			
Location:	AST TANK	FARM			Exa	m Start: 04/13/05	1004	Exam End:	2034			
Component ID:	AN103	7 4 444				mination Surfa	ce:	Nominal	0.875"			
Configuration:	PLAT	TO K	NUCKLE		Çal	⊠ OD □ ID □	.3" TO 1.0"	Thickness: Temp:	AMB °F			
Total Length Exami	ined:	Sc	on \Allette	40.0EF		nge: U. Level Correcti		oer):				
Procedure:	120"			10.85" ev	Ma	terial Type:		Cond	O DB			
COC	BEMA SVU	T-INS-007.3	3	2		SS X CS O	THER:		N/A			
File Name:	HORIZ.W	ÆLD (PLA	TE SIDE)			nsducer: ∄DUAL []SG	SL 🗵 O DE	3 ANGLE				
Xo Ref. Point (Lo): 1ST. AIR SLOT, WEST OF EAST AIRLINE, EAST OF 24" RISER												
Yo Ref. Point (Wo): CENTERLINE OF WELD												
Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk. (in) (in) (in) (in) R. Lig. (in) Reportable (in)												
0 - 12	(111)	(117)	(114)	147		.893	.842	Kepoitable	.910			
12 - 24						.890	.870		.910			
24 - 36				·	.886 .858			.910				
36 - 48					.887 .856			.910				
48 - 60					.887 .857							
48 - 60 .887 .857 .910 60 - 72 .884 .832 .910												
72 - 84	***					.886	.861		.910			
84 - 96						.883	.849		.910			
96 - 108						.881	.859		.905			
108 - 120						.881	.859		.905			
						<u> </u>						
		<u>L</u>	<u> </u>	<u> </u>		<u> </u>	<u>]</u>					
Remarks: Plate Side, P	eak-Edge (Contact Thic	kness Data	a								
Examiner: W. H.	Examiner: W. H. Nelson Examiner: Apalyst: J. B. Elder/ Reviewer: W. H. Nelson											
WASS	WHY Det WHY Dee											
Level: <u> </u> Date: _	04/13/05	Date		Lev	rel: <u>1</u> 1	<u> </u> Date: <u>6/30/</u>	05 Lev	rel: <u>Ill</u> Date:	7/17/05			
COGEMA-SYUT-INS-007	7.3 Rev. 2 Attach	ment 6	· · · · · · · · · · · · · · · · · · ·	<u> </u>			<u></u>	Re	v. Dec. C3. 2003			

AUTOM	ATED ULT	RASONICA REPOR		VESS		Job# O4	1-41	Ris	er# 25	,		
Location: 200 EA	AST TANK	FARM			Exa	m Start: 04/13/05	1004	Exa	m End:	2034		
Component ID:	AN103					mination Surfac			ninai ckness:	0.875"		
Configuration:	PLA	re to	KNUCKLE		Cal	ihrated	.3" то 1.0"			AMB ^O F		
Total Length Exam	ned: 47.8	* 8	can Width:	10.8"	Ref	'. Level Correcti	on (Trans. C	оп.):		O DB		
Procedure: COC	GEMA SVU	T-INS-007	3	Rev 2	Ma	terial Type: ISS ⊠ CS O	THER:		Cond	ition: N/A		
File Name:	HORIZ.W	ELD A (PL	ATE SIDE			nsducer:	SL 🔯 O DE	G	ANGLE	. 0		
Xo Ref. Point (Lo):	END OF I	FILE HORI										
Yo Ref. Point (Wo): CENTERLINE OF WELD Y Start												
Part # / Indication X Start (in) X Stop (in) Y Start (in) Y Stop (in) Ave. Thk. (in) Min. Thk., R. Lig. (in) Area Reportable (in) Max. Thk. (in) 0 - 12 .885 .863 .905												
0 - 12						.885	.863			.905		
12 - 24						.883	.858			.905		
24 - 36					·····	.883	.851			.905		
36 - 47.8						.884	.842			.905		
36 - 47.8 .884 .842 .905												
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			<u> </u>					_				
		<u> </u>						-				
			 					-				
Remarks:	<u> </u>	1				<u> </u>	<u>l</u>			<u> </u>		
Plate Side, P	eak-Edge (Contact Thi	ickness Da	ıta								
Examiner: W. H.	Nelson	Examiner:		A	alysty	J. B. Elder	Re	viewe	er: W. H.	Nelson		
WHILE	<u>n</u>			_(Ja	nessill	2/4	14	727e	<u></u>		
Level: III Date:	04/13/05	Dat	e;	_ L	vel: 1	II Date: 6/30/	05 Le	vel: <u>l</u>	I Date:	2/17/05		
1				1			ŀ					

AUTOM	ATED UL1 DAT/	RASON REPO		NESS			Job# O4	4-41	R	iser# 25	5
Location: 200 E/	AST TANK	FARM			E	.xa	m Start: 06/15/05	0900	E	xam End:	1300
Component ID:	AN103				E	×a	mination Surfa	Ce: PAINTEI		lominal hickness:	0.875"
Configuration:	PLA'	re to	KNUCKL			Cali	brated	.3" TO 1			AMB ^O F
Total Length Exam	ined: 71.5	**	Scan Width:	9.7*		₹ef.	Level Correcti	ion (Trans	. Corr	1	O DB
Procedure: COC	SEMA SVU		7.3	Rev 2			erial Type: SS 🖾 CS O	THER:		Cond	
File Name:	HORIZ,W	ELD B (F	LATE SIDI	E)		Trai	nsducer:		DEG	☐ ANGLE	0
Xo Ref. Point (Lo):					E OF		/ELD ATTA	·····			
Yo Ref. Point (Wo): CENTERLINE OF WELD											
Part # / Indication X Start (in) X Stop (in) Y Start (in) Y Stop (in) Ave. Thk. (in) Min. Thk., (in) Area (in) Max. Thk. (in) 0 - 12 870 .851 .885											
0 - 12						.870 .851			.885		
12 - 24						.868	.843			.885	
24 - 36							.866	.829			.880
36 - 48							.869	.850			.880
48 - 60				.867	.849			.880			
60 - 71.5							.869	.848			.885
											
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		ļ <u>.</u>									
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Pamarka:		<u> </u>					<u> </u>				<u> </u>
	Plate Side, Peak-Edge Contact Thickness Data Vert Weld 23 - 24" Plate Side										
Examiner: W.B.	Purdy	Examiner:		T	Analys	st:	J. B. Elder	7 1	Revie	wer. W. H.	Nelson
MOH	Workedy Janos Sille Washer										
Level: II Date: _ P-Scan Limited	Level: Date: 06/15/05 Date: Level: Date: 6/30/05 Level: Date: 2 17 6>										

AUTOMA	ATED ULT			VESS		Job# ∩₄		Ris	er# 25		
	DATA	REPOR	<u> </u>				T T	<u> </u>		<u></u>	
Location: 200 E/	ST TANK	FARM			Exa	am Start: 04/13/05	1014	Exa	m End:	2034	
Component ID:	AN103					amination Surfa			ninal ckness:	0.875"	
Configuration:	PLA"	re to k	NUCKLE		Cal	ibroted	.3" to 1.0"		7	AMB ^O F	
Total Length Exam	ned: 120"	, S	can Width:	10.8"		f. Level Correcti	on (Trans. C	оп.):		o DB	
Procedure:	SEMA SVU	T-INS-007	3	Rev 2	Ma	terial Type:]SS ⊠CS O	ruen.		Cond		
File Name:		ELD (KNUC			Tra	insducer:		=		ō	
Xo Ref. Point (Lo):						TOUAL S		<u> </u>	ANGLE		
Yo Ref. Point (Wo): CENTERLINE OF WELD											
CENTERLINE OF WELD Part # / Indication X Start X Stop Y Start Y Stop Ave. Thk. Min. Thk., Area Max. Thk.											
Part # / Indication X Start (in) X Stop (in) Y Start (in) Y Stop (in) Ave. 1 nk. (in) Min. 1 nk., R. Lig. (in) Area (in) Max. 1 nk. (in) 0 - 12 .939 .912 .947											
0 - 12						.939	.912			.947	
12 - 24						.936	.901			.947	
24 - 36						.940	.920			.947	
36 - 48						.940	.920			.947	
48 - 60						.939	.906			.947	
60 - 72						.940	.924			.947	
72 - 84			1			.937	.914			.947	
84 - 96						.939	.914			.947	
96 - 108						.930	.894			.947	
108 - 120		ļ	ļ <u></u>			.935	.912		<u> </u>	.946	
ļ			 			<u> </u>	 				
			<u> </u>				·				
		ļ				<u> </u>					
	-	 	 	-		 	<u> </u>	+			
Pomortes	<u> </u>		<u> </u>			1	<u> </u>		 		
Remarks: Knuckle Side	. Peak-Edo	e Contact	Thickness	Data							
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	į										
Examiner: W. H.	Examiner: W. H. Nelson Examiner: Analyst: J. B. Elder (1) Reviewer: W. H. Nelson										
W421	la-			_ 🖳	Bu	wb suco	5/6	UX	221e	b	
Level: III Date: _	04/13/05	Date):	_ Le	vel: <u>1</u>	I_ Date: <u>6/30/</u>	05 Le	vel; _[IL Date:	Hales	

AUTOM/		RASONICA REPORT		ESS		Job# O4	1-41	Ris	er# 25	;		
Location: 200 E/	AST TANK	FARM			Exa	m Start: 04/13/05	1014	Exa	m End:	2034		
Component ID:	AN103					mination Surface	ce:		ninal ckness:	0.875"		
Configuration:	PLA'	re ^{to} k	NUCKLE		Cal	ibrated	.3" TO 1.0"			AMB ^o F		
Total Length Exam	ined: 47.8	" S	can Width:	10.8"	Ref	f. Level Correcti	on (Trans. C	orr.):		O DB		
Procedure: CO	SEMA SVU	T-INS-007.	3	Rev 2	Ma	terial Type: ISS ⊠CS OT	THER:		Cond	ition: N/A		
File Name:	HORIZ.WE	LD A (KNU	CKLE SIDI	Ξ)	Tra	insducer:		 G	T ANGLE	0		
Xo Ref. Point (Lo):	END OF I	ILE HORIZ	Z.WELD	······								
Yo Ref. Point (Wo):	CENTER	LINE OF W	ELD									
Part # / Indication	X Start (in)	X Stop	Y Start (in)	Y Si	•	Ave. Thk.	Min. Thk., R. Lig. (in)	Re	Area portable	Max. Thk. (in)		
0 - 12 .939 .913 .947												
12 - 24												
24-36 .931 .914 .947												
36 - 47.8			.947									
			ļ <u>.</u>					4				
} ~————————————————————————————————————		<u> </u>				ļ		\bot				
						 						
	<u> </u>	<u> </u>				<u> </u>		_				
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		<u> </u>						-				
		<u> </u>		-	-	 		+				
			+					+				
Remarks:	<u> </u>	<u> </u>	<u>.J.</u>			<u> </u>	<u> </u>			<u> </u>		
Knuckle Side	e, Peak-Edg	e Contact	Thickness	Data								
	<u> </u>				_							
Examiner: W. H.		Examiner:		A ^{rt}	alyst:	J. B. Elder	<i>つ</i>	view	er: W.H. /2/1	Nelson		
Level: Ili Date:		Date	:	一 プ	242	II_ Date: _6/30/			Date:	7 nlos		
		, and			-]			- wn <u>. 1</u>	E Pare.			

AUTOMA	ATED ULT	RASONIO REPOR		VESS		O-	4-41	Ris	er# 25	5
Location: 200 EA	ST TANK	FARM			Exa	m Start: 06/15/05	0910	Exa	am End:	1310
Component ID:	AN103					mination Surfa	ce:		minal	0.875"
Configuration:	PLAT	TO N	KNUCKLE	· · · · · · · · · · · · · · · · · · ·	Cal	⊠ OD □ ID [brated 0	. 3" то 1 .		Clmess: Temp:	AMB °F
Total Length Exami			Scan Width:	9.7"	Ref	nge: U. Level Correcti				O DB
Procedure:				Pev		terial Type:			Cond	ition:
File Name	SEMA SVU			2		SS 🖾 CS O	THER:			N/A
Xo Ref. Point (Lo):	HORIZ.WEI	DB (KNU	ICKLE SID	E)		DUAL S	¥ ⊠0	DEG	☐ ANGLE	
Yo Ref. Point (Wo):		SCANNE	R AT WES	T SIDE (OF V	ELD ATTAC	CHMEN	<u> </u>		
To Rei. Foirt (VVo).	CENTER	INE OF W								
Part # / Indication	X Start (in).	X Stop (in)	Y Start	Y St (in		Ave. Thk. (in)	Min. Thi R. Lig. (′ 1	Area eportable	Max. Thk. (in)
0-12						.915	.886			.950
12 - 24						.937	.895			.950
24 - 36	· · · · · · · · · · · · · · · · · · ·					.931	.901			.945
36 - 48						.931	.892			.945
48 - 60						.931	.910			.945
60 - 71.5			ļ			.931	.902			.945
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				_		<u> </u>				
		<u> </u>	-	_		<u> </u>		\dashv	······	
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Remarks:	 	ł	-, L.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				<u> </u>	L		l
Knuckle Side Vertical weld				Data	<u></u>					
Examiner W.Q.	Purdy ,	Examiner:	-,	An	alyst:	J. B. Elder-	2 1	Review	er. W. H.	Nelson
PHO,01	Whon			_ 🗸	pr	res 5/ll	e	W	7 Mu	
Level: <u> </u> Date: _	6/15/05	Date	e:	Lev	/el: <u> </u>	Date: 6/30/	05	Level: _	II Date:	7/17/05
P-Scan Limited								·		
COGEMA-SVUT-INS-007	.3. Rev. 2. Attache	nent 6							Re	v. Dec. 03, 2003

	AUTO		D ULTRAS ATA REPO		SCAN		# doL)4-41	Riser	# 25	
Loca	tion:	40T TAX	UZ PARA	System:	PSP-4	Exar	n Start:	0057	Exam	n End:	
Com	200 E/	AST TAP	NK FARM	<u>-</u> L	FOF-4	Exar	04/13/05 nination Surf		Nomi	2027	
		AN103		····		⊠ (OD 🔲 OC	PAINTED	Thick	mess: 0.875	0"
	figuration:		PLATE TO	KNUCK		Ran		0" TO 3.5"		Temp: AMB	°F
Tota	l Length Exa	mined:	120"	Scan Widt	h: 7.6"			tion (Trans.	Соп):	<u>0</u> DB	
Proc	edure: CC	GEMA S	SVUT-INS-0	07.3	Rev. 2		erial Type: SS ⊠ CS (OTHER:	_	Condition: N/A	
File / Ite	Name m #:	***************************************	HORIZ.V	ÆLD	· · · · · · · · · · · · · · · · · · ·		nsducer:	SGL 🗆 0 DE	G D	ANGLE: 60	0
X _o F	Ref. Point (L _o)	18T.	AIR SLOT, \	WEST OF	EAST AIR	LINE	EAST OF	24" RISER	***************************************		
Y _o F	Ref. Point (W	<u>7:</u>				· · ·					
	Sizing Meth	od	Angle (deg)	Refer	ence Cal. Si	neet	T	Set-Up /	File Na	me	
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR 2 60° SHEAR 3 AATT 4 DUAL 0°											
1 45° SHEAR 2 60° SHEAR 3 AATT 4 DUAL 0°											
3	AATT										
4	DUAL 00										
				INDICA	ATION INFO	ORMAT	ION				
ind.	Method	Weld Side		ax. £1 mp. (in)	Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (In)	Indication Ty	ρe
						ļ <u>.</u>					
			<u> </u>							<u> </u>	
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						+		 		<u> </u>	
Re	marks:	<u> </u>				ــــــــــــــــــــــــــــــــــــــ		<u> </u>		<u> </u>	
1		(LIKE IN	DICATIONS			1					
	Examiner: W. H. Nelson Examiner: Analyst; J. B. Elder Reviewer: W. H. Nelson										
]	WH74 WH74 Level: Date: 7/6/05 Level: Date: 7/10/05 Level:										

	AUTO		D ULTR			CAN		Job#	0	4-41		er# 2:	5
Loca		AST TAI	NK FARN	1	System:	PSP-4	Exa	m Star 04/	t: 13/05	0957	Exe	ım End:	2027
Com	ponent ID:	AN103							n Surfa	ace:		ninal cknesa:	0.8750"
Con	figuration:		PLATE	TO	KNUCKLI	E	Ran			0" to 3.5"		Temp:	AMB °F
Tota	l Length Exa	nined:	45.4"		Scan Width:	7.6	Ref	Level	Согтес	tion (Trans.	Соп):		O DB
Proc	edure: CC	GEMA	SVUT-INS	S-007	.3	Rev. 2		eriaiT) SS ∑		OTHER:		Con	dition: N/A
File / Ite	Name n #:		HORIZ	.WEL	DA			nsduce DUAL	r. ⊠S	GL 00	EG	ANGLI	E: <u>60</u> °
	Ref. Point (L _o)	END	OF FILE	HORI	Z.WELD								
Yo F	Ref. Point (Wo): CEN	TERLINE	OF W	VELD								
	Sizing Meth	od	Angle (de	eg)	Refere	nce Cal.	Sheet			Set-Up	/ File I	Vame	
1 45° SHEAR 2 60° SHEAR													
3 AATT													
3 AATT													
4	4 DUAL 0° INDICATION INFORMATION												
		T Section	1 10 1-45 T	11					1440	188-92	14.65		
Ind.	Method	Weld Side	Depth R. Lig.	Max. Amp.		Lengi (in)	h L2 (in)		W1 (in)	VVidth (in)	W2 (In)	Indi	cation Type
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Γ													
1	Remarks: NO CRACKLIKE INDICATIONS												
4	April Date: Date												

- · · · · -	AUTC		D ULTRASO ATA REPO		CAN		-	04-41		25			
Loca		AST TAN	NK FARM	System:	PSP-4	Exam	n Start: 06/15/05	0920	Exam End	1320			
Соп	ponent ID:	AN103						face:	Nominal Thickness				
	figuration:		PLATE TO	KNUCKL		Rang		0" TO 3.5"	Temp	^X AMB ^o F			
<u> </u>	l Length Exan	nined:	69.1"	Scan Width	8.4"			ction (Trans. C		<u>0</u> DB			
Proc	edure: CO	GEMA S	SVUT-INS-00	7.3	Rev. 2		erial Type: SS ⊠CS (OTHER:	_ Co	ondition: N/A			
/ ite			HORIZ.WE	LD B			sducer: DUAL ⊠ S	SGL 0 DE	G ⊠ANG	ele: <u>60</u> °			
X _o F	Ref. Point (L _o):	BACK	OF SCANN	ER AT WE	EST SIDE	OF W	ELD ATTA	CHMENT					
Y ₀ F	Ref. Point (Wo): CENT	TERLINE OF	WELD									
Sizing Method Angle (deg) Reference Cal. Sheet Set-Up / File Name 1 45° SHEAR													
1 45° SHEAR 2 60° SHEAR													
2 60° SHEAR 3 AATT													
3 AATT													
4 DUAL 0°													
	INDICATION INFORMATION												
Ind.	Method	Weld Side	Depth Ma R. Lig. Am	5	Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (in) Ind	dication Type			
	<u></u>	Side	(V. 170)	ib. (/iii)	'"'	(1117	(41)	 \"' 					
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L.	marks:					1							
		LIKE IN	DICATIONS										
Eva	miner ON) Purely	Examiner:		I Kr	alvst	B Fider	Pe	viewer W I	H Nelson			
<u>U</u>	Examiner: W. D. Purdy												
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	AUTO		D ULTRA DATA REF			CAN		Job#	04-41	Ris	er# 25	
Loca					System:		Exar	n Start:		Exa	ım End:	
		AST TA	NK FARM			PSP-4		06/01/05			1350	
	ponent ID:	AN103					⊠ (nination Sur			minal ckness: 0.8750"	
	iguration:		PLATE TO	1	KNUCKL		Ran	, - -	0" TO 2.4		Temp: AMB °F	
	l Length Exar	nined:	120"		Scan Width	6.4"		Level Correc	tion (Trans	s. Соп): 	<u>0</u> DB	
Proc	edure: CO	GEMA	SVUT-INS	-007	.3	Rev. 2		eriad Type: SS ⊠CS	OTHER:		Condition: N/A	
File / iter	Name n#:	НО	RZ.WELD/	2 ND /F	KNUCKL	E		sducer. DUAL 🔯	SGL 🔲 0	DEG	⊠ ANGLE: 45°	
X₀ F	Ref. Point (Lo)	1 ST	AIR SLOT,	WES	ST OF E	AST AIRL	INE, E	AST OF 2	4" RISEF	₹		
Y _o F	Ref. Point (Wo): CEN	TERLINE (OF W	ÆLD				·······			
	Sizing Meth	ed	Angle (deg)	Refere	ence Cal. Sh	eet		Set-U	p / File N	√ame	
1	45° SHEAR											
2 60° SHEAR 3 AATT												
3 AATT												
4 DUAL 0°												
					INDICA	TION INFO	ORMAT	ION				
ind.	Method	Weld Side	Depth R. Lig.	L1 (in)	Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type		
		 	 -				 			,		
												
		<u> </u>	-				-					
		<u> </u>					 					
<u> </u>												
ł	Remarks: NO CRACKLIKE INDICATIONS											
Exa	miner: W. [UDH		Exami	ner.			alyst: .	J. B. Elder 23 (5 / Car		Reviewe	r. W. H. Nelson	
•	.evel: Date: 06/01/05 Date: Level: Date: 7/6/05 Level: Date: 7 17 05											

	AUTO		ULTRAS ATA REPO		CAN		Job#	04-41	Riser#	25			
Loca		AST TAN	K FARM	System:	PSP-4	Exar	n Start: 06/01/05	0847	Exam E	nd: 1350			
Com	ponent ID:	AN103				Exar IXI (nination Surf		Nomina	0.0750			
Conf	iguration:	P	LATE TO	KNUCKL	.E		orated	0" to 2.47 '	Te	mp: AMB °F			
Tota	i Length Exa	nined:	14.7"	Scan Width	^{1:} 5.4"	Ref.	Level Correc	tion (Trans.	Сопт):	<u>0</u> DB			
Proc	edure:	GEMA S	VUT-INS-0	07.3	Rev. 2	Mate	erial Type: SS 🔯 CS (OTHER:		Condition: N/A			
File / Iter	Name n #:	HORZ	.WELD/2 ND	KNUCKLE	A	Tran	sducer.	SGL □ 0 DE	=	NGLE: 45°			
X _o F	Ref. Point (L _o)	END C	OF FILE HO	RZ.WELD/	2 ND /KNUC	KLE							
Yo F	Ref. Point (Wo): CENT	ERLINE OF	WELD									
	Sizing Meth	od	Angle (deg)	Refere	ence Cal. Sh	eet		Set-Up /	File Name	В			
1 45° SHEAR 2 60° SHEAR													
1 45° SHEAR													
3 AATT													
4 DUAL 0°													
	INDICATION INFORMATION												
ind.	Method	Weld Side	, ,	lax. L1 mp. (in)	Length (in)	L2 (in)	W1 (in)	Width (in)	W2 (in)	Indication Type			
	·				<u> </u>	<u> </u>							
										·			
	·	· ·			_								
	Remarks: NO CRACKLIKE INDICATIONS												
Lev	Examiner: AV D. Purdy Examiner: Analyst: J. B. Exter WH. Nelson WH. Nelson Level: II Date: 06/01/05 P-Scan Limited Level: III Date: 7/6/05 Level: III Date: 7/6/05												

	AUTO		D ULTR			CAN		Job#	04-41	Riser#	25		
Local		AST TA	NK FARN		System:	SP-4	Exan	n Start: 05/27/05	0825	Exam En	d: 1400		
Com	ponent ID:	AN103			<u> </u>	<u> </u>	Exam	nination Sur	face:	Nominal			
Confi	iguration:		PLATE	TO	KNUCKLE		Calib	rated	☐ PAINTED 0" TO 2.47"	Thicknes Tem			
Total	Length Exam		75.4"		Scan Width:		Rang Ref.		ction (Trans.	j			
Proc	edure:			[Rev.	Mate	rial Type:			<u>0</u> DB condition:		
File	CO Name		SVUT-IN			2		SS 🗵 CS	OTHER:		N/A		
/ Iten	n #:		Z.WELD/	2 ND /KI	NUCKLE	B			SGL 0 DE	G ⊠AN	IGLE: 45°		
	ef. Point (L _o)	BAC	K OF SC	ANNE	R AT WE	ST SIDE	OF W	ELD ATT	ACHMENT				
Y ₀ R	ef. Point (Wo): CEN	TERLINE	OF W	VELD								
	Sizing Meth		Angle (d	eg)	Referer	nce Cal. Sh	eet		Set-Up /	File Name			
2	45° SHEAR 60° SHEAR				<u> </u>								
3	AATT												
4	4 DUAL 0° INDICATION INFORMATION												
	Weld Denth May 11 1							ION W1	Width	W2 .	- 1r - kb		
Ind.	Method	Side	R. Lig.	Атр.	1	(in)	1.2 (in)	(in)	(in)	(in)	ndication Type		
\vdash		<u> </u>							 		······································		
				-		 		+					
											3		
			<u> </u>			<u> </u>							
		ļ	 										
		<u> </u>							+				
		 	 	 -		 	 	-	 	<u> </u>			
	narks:		<u></u>	I.,,,,,			L		<u></u>				
N	NO CRACKLIKE INDICATIONS												
Exa	miner W. [). Purdy	Exar	niner:			alyst:	J. B. Elder	Pro Re	viewer. W	H. Nelson		
Lev	el: <u>II</u> Date:	05/27/0	<u>ک</u>	Dat	e:	_ {.	vel: <u>III</u>	Date: _7/6	<u>/05</u> Le	vel: <u> </u> Da	te: 7/17/05		
L	-Scan Limited												
COG	FMA-SVUTJNSJ	2073 Rev 5	2. Attachment 5	5							Rev. Dec. 03, 2003		

-	AUT		TED ULT CALIBRA				SS		Job#		05-41		Riser		25
Location	200	EAS	T TANK F	ARM	Syster	n: 103-	AN		bration lock:	44	4-99-30	-004			
Procedu	ıre:	COGE	EMA SVUT	-INS-007	'.3	Rev.	2	Thic	kness:	0.3'	' to 1.0'	, Ma	terial:	Cart	on Steel
UT Syst	lem:	F	PSP-4	Serial I	No.	405			rence lock:				N/A		
Software	e Vers	ion:	P-SCAN	Sys. 4 1	1.3	Rev.	2	Thic	kness:		N/A	Ma	terial:		N/A
Linearity	y Due	Date:	06/30	/2005		_ 		Refe	erence	Block	Temp:	AM	в ^о ғ		
Scanne	r Type	:	AGS-2	Serial I	No. 40	1		Сои	plant:	W	ater		tch No.		N/A
Scanne	r Cabl	e:	COAXIAL					Cab	le Leng	th:	10	0 Fe	et		
Signal (Cable:		COAXIAL			·		Cab	le Leng	rth:	10	0 Fe	et		
Chann	nel		nsducer Vlake	Mode	÷I	Freq. (MHz)	1	Size		Ser	ial No.		gle eg)		Wedge Type
1			KB	MSE	В	5		0x2MI	M	02	2002	<u>-</u> -))	<u> </u>	Туре
2			*KB	MSE	В	5		x2M	М	0	1997	(0		
3															
4															
INITIAL CALIBRATION CHECKS															
DATE: 04/04/05 04/04/05 04/11/05 04/11/05 04/12/05 04/12/05 04/18/05 04/18/05															
TIME: 1016 1954 1008 2011 0826 1441 0922 2130															
REFLE	REFLECTOR: 3"-1,6" 3"-1.0" 3"-1.0" 3"-1.0" 3"-1.0" 3"-1.0" 3"-1.0" 3"-1.0"														
CH. 1	THK	. 1	.303"	.301"		298"	.296	•	.30	1"	.308	3" <u> </u>	.296	3"	.296"
V.1.	THK	. 2	1.00"/0db	.999°/0d	b 1.0	0°/0db	.995"/0)db	1.00"/	0db	1.005"/	-1db	1.00%	0db	.999"/2db
CH. 2	THK	. 1	.301"	.299"	<u>.</u>] .	298"	.296	"	.30	3"	.305	BH	.296	3"	,296"
OH, Z	THK	. 2	1.00°/0db	.999"/-10	b 1.0	07/ 0 db	.995"/(db	1.00"/	0db	1.005"/	-1db	1.00"/	Odb	.996"/2db
CH. 3	THK	. 1	.299"	.299"		298"	.296	*	301	"	.305	5"	.296	3"	.294"
011.5	THK	. 2	1.00"/0db	.999"/-10	ib 1.0	0"/0db	.995"/0)db	1.00"/	0db	1.005"/	-1db	1.00"/	0db	.997"/2db
CH. 4	THK	. 1					i				<u> </u>				
	THK	. 2													
EXAM	IINER	:	WHN	WHN	\	NHN	WHI	N	WH	N	WH	N	WD	P	WDP
Remarks: CAL-T * Transducer 01997 used on 4/18/2005.															
Exami	Examiner: W.D. Purdy Examiner: W. H. Nelson Reviewer; W. H. Nelson WD Hurdy WHY WHY														
Level:		Date imited		<i>i</i> 05	Level:	<u> </u> Da	ate: 0	4/04-	12/05		Level: _	<u>IIL</u> (Date:	07/1	7/2005
L			Rev 2. Attachi										···		v Dec 03 2003

	AUTON	IATED UI CALIBRA				ı	Job#		05-41		Riser	2	5
Location	200 EAS	ST TANK F.	ARM	Syster	n: 103-/	AN	Calibration Block:	44	14-99-30)-00·	1/002		
Procedu	re:	MA SVUT-		3	Rev.	2	Thickness:		1.0"	М	aterial:	Cart	on Steel
UT Syste	em:	PSP-4	Serial N	ło.	405	1	Reference Block:				N/A		
Software	Version:	P-SCAN	Sys. 4 1	.3	Rev.	2	Thickness:		N/A	M	aterial:		N/A
Linearity	Due Date:	06/30	/2005				Reference	Bloci	k Temp:	ΑN	1B °F		
Scanner	Туре:	AGS-2	Serial N	^{vo.} 40	1		Couplant:	٧	Vater	В	atch No.		N/A
Scanner	r Cable:	COAXIAL					Cable Leng	gth:	10	0 F	eet		
Signal C	Cable:	COAXIAL					Cable Leng	gth: 	10	0 F	eet		
Chann	PII	nsducer Make	Mode	el	Freq. (MHz)		Size	Se	rial No.		e (deg) ı. / Act.		Wedge Type
1		KB	MW	3	4	8:	x9mm		3142		45		
2	2 KB MWB 4 8x9mm 3140 45 3												
	4												
INITIAL CALIBRATION CALIBRATION CHECKS													
DATE: 04/04/05 04/04/05 04/11/05 04/11/05 04/12/05 04/12/05 04/15/05 04/15/05													
TIME:													
	REFLECTOR / .050"												
	AMPLITUDE	80%/0db	80%/0dt		%/0db	80%/0d			80%/2		80%/0		80%/-1db
CH. 1	LOCATION	1.414"	1.397"	1	.414"	1.396	1.41	4"	1.40	4"	1.41	4"	1.404"
CH. 2	AMPLITUDE	80%/0db	80%/-2dl	b 80	%/0db	80%/-20	db 80%/	Odb	80%/1	db	80%/0	Odb	80%/-2db
On. 2	LOCATION	1.414"	1.404"	1	.414"	1.410	1.41	14"	1.40	1"	1.41	4"	1.427"
CH. 3	AMPLITUDE								<u> </u>				
	LOCATION									······			
CH. 4	AMPLITUDE								<u> </u>		<u> </u>		
	LOCATION								1000				
										WHN			
Remarks: CAL.P													
	Examiner: W. H. Nelson Examiner: Reviewer: W. H. Nelson WD Du												
Level:	<u>III</u> Dat	e: 4/4-15	5/05	Level:	Da	ite:			Level: _	<u>III</u>	Date:	07/	17/2005
COGEMA-	SVUT-INS-007.	3, Rev. 2, Affachr	nent 3		· · · · · · · · · · · · · · · · · · ·							Re	v. Dec. 03, 2003

	Α	UTON	ATED U						Job#		04-41		Riser		!5
Locatio	n: 20	00 EAS	ST TANK F	ARM	Syste	m: 103-A	N		libration Block:	4.	44-99-3	0-00	1/002		
Proced	ure:		MA SVUT		.3	Rev.	2		ckness:		1.0"	М	laterial	Car	bon Steel
UT Sys	tem:		PSP-4	Serial	No.	201		f	ference Block:				N/A		
Softwar	re Ve	rsion:	P-SCAN	 I Sys. 4	1.3	Rev.	2		ckness:		N/A	М	aterial:		N/A
Linearit	ty Du	e Date:)/2005				Ref	erence	Bloc	k Temp:	<u> </u>	∕B °F		
Scanne	er Typ	oe:	AWS-5d	Serial	No. 31	^		Co	uplant:		Vater		atch No.		 N/A
Scanne	er Cal				31	<u> </u>		Cal	ble Leng						N/A
Signal	Cable	9:	COAXIAL					Cal	ble Leng	jth:		30 F			
Chan		Tra	COAXIAL nsducer		al.	Freq.	<u> </u>	Size		c.	rial No.	30 F	e (deg)		Wedge
Channel Make Model (MHz) Size Serial No. Angle (asg) Verge 1 KB MWB 4 8x9mm 2-3200 60												Туре			
1 KB MWB 4 8x9mm 2-3200 60 2 KB MWB 4 8x9mm 2-3029 60															
3															
ļ	4 CALIBRATION CALIBRATION CHECKS														
DATE	:		04/13/05	04/13/0	5 04	/14/05	04/14/	05	05/09	/05	05/09	/05	05/12	/05	05/12/05
TIME:			0957	2027	(0846	1537	•	132	1	194	5	093	5	1440
REFLI ORIE			.050" Notch	.050" Notch		050" Notch	.050' Notel		.050 Note		.050 Note		.050 Note		.050" Notch
CH. 1	АМР	LITUDE	80%/0db	80%/2d	b 80	%/0db	80%/2	db	80%/	0db	80%/-	2db	80%/)db	80%/0db
	LOC	ATION	2.00"	1.993'		2.00"	1,990)"	2.00)"	1.99	0"	2.00)"	1,990"
CH. 2	<u> </u>	LITUDE ATION	80%/0db	80%/-20		%/0db	80%/1		80%/		80%/		80%/		80%/2db
 -	├	LITUDE	2.00"	2.007	+	2.00"	1.990		2.00	J 	1.99	5	2.00		1.976"
CH. 3		ATION													
CH. 4	AMP	LITUDE													
	ł .	ATION			_ _										
EXAM		₹:	WHN	WHN	\	WHN	WHN	4	WD	Р	WD	Р	WH	N	WHN
	temarks: CAL.P2														
Exam	iner:	W.D.	Purdy		Examin	er: W. H.	Nelso	ìΠ			Reviewe	er: W	/. H. Ne	ison	
	<u>ر ر</u>	121-	Mouri		WX	2/	le_	<u></u>		_	Wt	9/	Sels		-
Level:	***************************************	Date	e: 5/9/0) 5	Level:			13 - E: 1.	14/0 2/05	5	Level: _	<u> </u>	Date:	07 <i>l*</i>	17/2005
P-S	can l	_imited				سابق	'	- W	-10>						

Location: 200 EAST TANK FARM			IATED UL CALIBRA			-SCAI	1	Jo	ob#	04-41		Riser #	25	
Procedure: COGEMA SVUT-INS-007.3 Rev. 2 Thickness: 1.0" Material: Carbon Steel	Location	1:				n: 103-	AN			144-99-30)-00·	1/002		
PSP-4 201 Block: N/A N/A	Procedu	re: COGE	MA SVUT-I	NS-007.3	3		****					aterial:	Carbon Steel	
P-SCAN Sys. 4 1.3 Rev. 2 Thickness: N/A Material: N/A	UT Syst	tem:	PSP-4	Serial N	lo.	201						N/A	**************************************	
O6/30/2005 Scanner Type: AWS-5d Serial No. 310 Couplant: Water Batch No. N/A	Softwar	e Version:	P-SCAN	Sys. 4 1	.3	Rev.	2			N/A	М	aterial:	N/A	
AWS-5d 310 Water N/A	Linearit	y Due Date:	06/30/	2005			· ·-·	Refere	nce Blo	ck Temp:	AN	1B °F		
COAXIAL Cable Length: 80 Feet	Scanne	r Type:	AWS-5d	Serial N	31	0		Coupla	ent:	Water	В	atch No.	N/A	
COAXIAL Channel Transducer Make	Scanne	r Cable:	COAXIAL					Cable	Length:	8	0 F	eet		
Make	Signal (Cable:	COAXIAL					Cable	Length:	8	0 F	eet		
2 KB MWB 4 8x9mm 03242 45 3 KB MWB 4 8X9MM 03287 45 4 KB MWB 4 8X9MM 03286 45 INITIAL CALIBRATION	Chann	3 (2) }		Mode	1			Size	S	Berial No.				
3 KB MWB 4 8X9MM 03247 45 4 KB MWB 4 8X9MM 03286 45 INITIAL CALIBRATION CALIBRATION CHECKS DATE:	1		KB	MWE	3	4		x9mm		03334		45		
A KB MWB 4 8X9MM 03286 45			KB	MWE	3	4		x9mm		03242		45		
INITIAL CALIBRATION			KB	MWE	3	4				03247		45		
DATE:		- 1 NB WIVID 4 OASWIN 03280 45												
TIME: 0808 2025 0825 1400 0847 1350 REFLECTOR / 0.50"														
REFLECTOR / OS0" Notch		···	05/26/05	05/26/05	05/	27/05	05/27/	05 0	6/01/05	06/01/	05			
ORIENTATION: Notch 80%/0db 80%/0db 80%/0db 80%/0db 80%/0db 80%/0db 80%/0db 80%/0db 80%/-1db 80%/0db 80%/-1db 80%/-1db 80%/0db 80%/-2db	TIME:		0808	2025	0	825	1400		0847	1350	2			
CH. 1 LOCATION 1.414" 1.404" 1.414" 1.417" 1.414" 1		-												
LOCATION		AMPLITUDE	80%/0db	80%/0db	80°	%/0db	80%/-1	db 8	10%/0db	80%/0	db			
CH. 2 LOCATION 1.414" 1.407" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.411" 1.414" 1.411" 1.411" 1.414" 1.411" 1.411" 1.411" 1.414" 1.411" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.411" 1.414" 1.414" 1.411" 1.414" 1	CH. 1	LOCATION	1.414"	1.404"	1.	414"	1.417	'ta	1.414"	1.414	4"			
LOCATION 1.414" 1.407" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.414" 1.411" 1.414" 1.414" 1.411" 1.414"	CH 2	AMPLITUDE	80%/0db	80%/1db	809	%/0db	80%/0	db 8	0%/0db	80%/-	ldb			
CH. 3	Urt. 2	LOCATION	1,414"	1.407"	1.	414"	1.414	"	1.414"	1.414	4"	**************************************		
LOCATION 1.414" 1.411" 1.414" 1.411" 1.414" 1.411"	211.2	AMPLITUDE	80%/0d	80%/2db	80	%/0db	80%/-2	db 8	0%/0db	80%/-	1db			
CH. 4 LOCATION 1.414" 1.407" 1.414" 1.407" 1.414" 1.411" EXAMINER: WDP WDP WDP WDP WDP WDP Remarks: CAL.P4 CAL.P4 Examiner: Reviewer: W. H. Nelson WDP Level: II Date: 5/26-6/1/05 Level: Date: Level: III Date: 07/17/2005	Cm. 3	LOCATION	1.414"	1.411"	1.	414"	1.411	11	1.414"	1.41	1"			
LOCATION 1.414" 1.407" 1.414" 1.414" 1.411"	CH 4	AMPLITUDE	80%/0db	80%/1db	80'	%/0db	80%/-1	db 8	30%/0db	80%/-2	2db			
Remarks: CAL.P4 Examiner: W.O. Purdy Examiner: Reviewer: W. H. Nelson W.D. Julian Level: II Date: 5/26-6/1/05 Level: Date: Level: III Date: 07/17/2005	C11. 4	LOCATION	1.414"	1.407"	1.	.414"	1.407	-11	1.414"	1.41	1"			
Examiner: W. Q. Purdy Examiner: Reviewer: W. H. Nelson Level: II Date: 5/26-6/1/05 Level: Date: Level: III Date: 07/17/2005	EXAM	INER:	WDP	WDP	V	VDP	WDF	>	WDP	WDI	>			
Level: <u>II</u> Date: 5/26-6/1/05 Level: Date: Level: <u>III</u> Date: 07/17/2005		· · · · · · · · · · · · · · · · · · ·												
Level: <u>II</u> Date: 5/26-6/1/05 Level: Date: Level: <u>III</u> Date: 07/17/2005	Exami	ner: WND	Purdy	F	xamin	er:				Reviewe	r: W	/. H. Ne	Ison	
<u></u>		3 P.L	when	ļ.		·		· · · · · · · · · · · · · · · · · · ·				Zu		
Li Vinna Limitadi	1 .	_) 05 L	.evel: _	Da	ite:			Level: _l	11	Date:	07/17/2005	
P-Scan Limited COGEMA-SYUT-INS-007.3, Rev. 2, Attachment 3 Rev. Coc. 03, 2003	L								·	<u> </u>			Day Gr. 42 2022	

,	OTU	MATED ULT CALIBRA				SS	Job #		05-41		Riser		25
Location	200 E	AST TANK F	ARM	Syster	n: 102-	AN	Calibration Block:	44	14-99-30	-004			
Procedu	re: C(OGEMA SVU	Γ-INS-007	7.3	Rev.	2	Thickness:	0.3	" to 1.0"	Ma	terial:	Carl	oon Steel
UT Syst	em:	PSP-4	Serial 1	Vo.	201		Reference Block:				N/A		
	e Versio	P-SCAN	I Sys. 4 1	1.3	Rev.	2	Thickness:		N/A	Ma	terial:		N/A
Linearity	y Due Da	ate: 06/30	/2005				Reference	Block	(Temp:	AMI	в ^о ғ		
Scanne	r Type:		Serial I	No. 31(0		Couplant:	٧	Vater	Bat	ch No.		N/A
Scanne	r Cable:	COAXIAL	•				Cable Leng	gth:	80) Fe	et		
Signal (Cable:	COAXIAL	•				Cable Leng	gth:	80) Fe	et		
Chann	el	Transducer Make	Mode	∍i	Freq. (MHz)		Size	Se	rial No.	Anı (de			Wedge Type
1		KB	MSE	В	5	8	x2MM	0	1939	C			
2		*KB	MSE	В	5		3x2MM	0	1997)	<u> </u>	
3		*K8	MSE	В	5	3	3x2MM	0	2005)		
4			,		<u> </u>		···					<u> </u>	
		LIBRATION	 				ALIBRATIO		HECKS				
DATE:		04/15/05	04/15/05	5 04,	/18/05	04/18/	05 06/02	2/05	06/02/0)5	06/02	/05	06/02/05
TIME:		1039	2044		0834	2138	084	43	1915		085	6	1921
REFLE	ECTOR:		3"-1.0"	.3'	"-1.0"	.3"-1.0)" .3"-1	.0"	.3"-1.0)"	.3"-1.	.0"	3"-1.0"
CH. 1	THK. 1		.299"		303"	.299	.29	8"	,296"		.303	3"	.303"
	THK. 2	1.00"/Odb	1.00"/0d1		0"/0db	.996"/-1	db 1.00"	/Odb	.995"/0	db	1.00"/	0db	1.00"/1db
CH. 2	THK. 1	,299"	.295**		303"	.299	.30	3"	.301"		.299)"	.299"
 	THK. 2	1.00°/0db	.996"/0dl	b 1.0	0"/0db	.996"/0	ldb 1.00"	/Odb	.997"/0	db	1.00"/		1.00"/1db
CH. 3	THK. 1	.299"	.295*	:	303"	.299	.29	8"	.301"		.299	} "	.299"
ļ	THK. 2	1.00"/Odb	.993"/0dl	b 1.0	0"/0db	996"/0	db 1.00"	/0db	.997"/0	db	1.00"/	0 db	1.00"/1db
CH. 4	THK. 1		ļ	_					 		·····		
EXAM	<u></u>	WHN	WHN	\ \ \ \	NDP	WDF	, WI	IN	WHN	$\neg +$	WH	N	WHN
Rema CAL *Tra	rks: T2 ansduc	er 01997 & 02	005 used	on 6/2					Reviewer				
Level:	11	Date: 4/18	/05	Level:	42 111 Da	<u> Jes</u> ne: 6	-2-05	_		12	lel- Date:	07/1	17/2005
P-S	can Lim	ited											

COGEMA-SVUT-INS-007.3, Rev. 2, Attachment 1

	AUTO		TED ULT				SS		# doL		04-41		Rise		25
Location	200 E	EAS	T TANK FA	ARM	Syste	^{m:} 103-	AN		bration lock:	44	4-99-3	0-004			
Procedu	re: C	OGI	EMA SVUT	-INS-00	7.3	Rev.	2	Thic	kness:	0.3	" to 1.0	Ma	iterial:	Cart	oon Steel
UT Syst	em:	F	PSP-4	Serial	No.	201			erence lock:				N/A		
Software			P-SCAN	Sys. 4	1.3	Rev.	2		kness:		N/A	Ma	iterial:		N/A
Linearity		ate:	06/30/	2005				Refe	erence	Block	Temp:	AM	в ^о ғ		
Scanner	r Type:		AWS-5d	Serial	No. 31	0		Cou	plant:	V	/ater	Ba	tch No.		N/A
Scanner	r Cable:		COAXIAL					Cab	le Leng	th:	ε	30 Fe	et		
Signal C	Cable:		COAXIAL					Cab	ie Leng	th:	8	30 Fe	et		
Chann	el		nsducer Make	Mod	iel	Freq. (MHz)		Size		Sei	rial No.		gle eg)		Wedge Type
1			KB	MS	ΞВ	5	8	x2MI	М	0	1939)		
2		······	KB	MS	ΞB	5	8	x2M	М	0:	2002	- 1)		
3			*KB	MSI	EB	5	8	x2MI	М	0	1997		0		
4															
INIT	IAL CA	LIBE	RATION				CA	LIBE	RATIO	N CH	ECKS				
DATE:			05/09/05	05/09/0	5 05	/09/05	05/09/0)5	05/12	/05	05/12	/05	05/12	/05	05/12/05
TIME:			1330	1330		1934	1939		091	5	092	1	144	2	1442
REFLE	CTOR	:	.3"-1.0"	.3"-1.0	* .3	5"-1.0"	.3"-1.0)"	.3"-1	.0"	.3"-1	0"	.3"-1	.0"	.3"-1.0"
CH. 1	THK. 1		.301"	.298"		298"	.298"		,301	"	.301	4	.298	3"	.298"
CH. 1	THK. 2	2	1.00"/0db	.999"/20	ib 1.0	00"/0db	.993"/0	đb	1.00"/	0db	1.00"/	0db	.999"/	0db	.999"/-2db
ÇH. 2	THK. 1		.298"	.292"		298"	.298"	•	.298	3"	.301	*	.298	3"	298"
On 2	THK, 2	2	1.00"/0db	.993"/2	Jb 1.0	00"/0db	.996"/1	db	1.00"/	0db	1.00%	0db	. 99 9"/	0db	.999"/-2db
CH. 3	THK. 1	1	301""	.295"		298"	.298"		.298	3"	.301	1"	.295	5"	.298"
CH. 3	THK. 2	2	1.00"/0db	.996"/2	db 1.6	00°/0db	.999"/0	db	1.00"/	0db	1.00"/	Odb	.993"/	1db	.999"/-1db
CU 4	THK. 1	1	,												
CH. 4	THK, 2	2													
EXAM	NER:		WDP	WDP	1	WDP	WDP		WH	N	WH	N	WH	N	WHN
Remar CAL *Tra	.T4	er#	01997 used	d with #0)1939 (on 5/12/	05				•				
Exami	ner: (V	V.Q.	Purdy		Examir	ier: W. F	l. Nelso	n	***************		Reviewe	er: W.	H. Ne	Ison	
w	\mathcal{D}_{I}	<u>ر</u>	hon		4	401	Zu_			_	101	1)=	Ru		
1	Level: <u>II</u> Date: 5/9/85														

COGEMA-SVUT-INS-007.3, Rev. 2, Attachment 1

Rev. Dec 03, 2003

,	AUTOM	ATED ULT CALIBRA				SS	Job#	04-41		Rise	25
Location	n: 200 EA	ST TANK F	ARM	Syster	^{n:} 103-	AN	Calibration Block:	444-99-3	0-004	·	
Procedu	CO	GEMA SVUT			Rev.	2	Thickness:	0.3" to 1.0	" Ma	terial:	Carbon Steel
UT Syst		PSP-4	Serial N	lo.	201		Reference Block:			N/A	
	e Version:		Sys. 4 1	.3	Rev.	2	Thickness:	N/A	Ма	terial:	N/A
	y Due Date	06/30	2005				Reference	Block Temp:	AMI	в ^о ғ	
Scanne		AWS-5d	Serial N	lo. 31(0		Couplant:	Water	Bat	lch No.	N/A
	r Cable:	COAXIAL					Cable Leng	gth: {	30 Fe	et	
Signal (Cable:	COAXIAL					Cable Leng	gth:	30 Fe	et	
Chann	iel T	ransducer Make	Model	1	Freq. (MHz)		Size	Serial No.	Anı (de		Wedge Type
1		KB	MSEE	3	5	8	x2MM	01939	C)	
2		KB	MSEE	3	5	9	x2MM	02005	C)	
3											
4	CAL CAL	BRATION			<u> </u>		LIBRATIO	N CHECKS	<u> </u>		<u> </u>
DATE:		06/15/05	06/15/05	ne	/15/05	06/15/0		IN CHECKS			
TIME:		0900	0910	+	300	1310	- 				
	ECTOR:	,3"-1.0"	.3"-1.0"		"-1.0"	.3"-1.0		· · · · · · · · · · · · · · · · · · ·			
1,2,0	THK. 1	.298"	.298"	-	298"	.298"					
CH. 1	THK, 2	1.00"/Odb	1.00°/0db		0"/0db	.993"/0					
	THK. 1	298"	.298"		295"	.298"					
CH. 2	THK. 2	1.00"/0db	1.00"/0db	.99	6"/1db	.996"/20	db				
A	THK. 1	.298"	.298"	.	295"	.292"					
CH. 3	THK. 2	1.00"/0db	1.00°/0db	.99	6°/-2db	.996"/1	db				
CH. 4	THK. 1										
	THK, 2										
EXAM	INER:	WDP	WDP	1	NDP	WDP		<u> </u>			· · · · · · · · · · · · · · · · · · ·
Rema CAL	rks: T6										
Exami	iner: W.	D. Rurdy .	E	xamin	er:	<u></u>		Review	er: W.	H. Ne	elson
	<u>70</u>	July 1	Jul _	• • • • • • • • • • • • • • • • • • • •				WH	12	2er	
Level:		ate: 6/15/	05 U L	.evel:	Da	ate:		Level:	<u>III</u> C	ate:	07/17/2005
P-Se	can Limite	ed									

COGEMA-SVUT-INS-007.3, Rev. 2. Attachment 1

Rev Dec. 03, 2003

	AUTO	MATED UI			-	İ	Job#	ļ	04-41		Riser		5
Location	: 200 EA	ST TANK F	ARM	Syster	n: 103-A	λN	Calibration Block:	44	4-99-30	-00	1/002		
Procedu	re: COG	EMA SVUT	INS-007.	3	Rev.	2	Thickness:		1.0"	М	aterial:	Cari	oon Steel
UT Syst	em:	PSP-4	Serial N	lo.	201		Reference Block:				N/A		
Software	e Version:	P-SCAN	Sys. 4 1	.3	Rev.	2	Thickness:		N/A	M	aterial:		N/A
Linearity	Due Date:	06/30	/2005				Reference	Block	Temp:	ΑN	1B ^O F	*************************	
Scanner	Туре:	AWS-5D	Serial N	No. 31	0		Couplant:	W	ater	B	atch No.		N/A
Scanner	Cable:	COAXIAL					Cable Len	gth:	80	O F	eet		
Signal C	Cable:	COAXIAL					Cable Len	gth:	80	D F	eet		
Chann	el Tr	ansducer Make	Mode	:	Freq. (MHz)		Size	Ser			e (deg) ı, / Act.		Wedge Type
1		КВ	MWE	3	4	ε	3x9mm	0:	3334		45		
2		КВ	MWE	3	4	8	3x9mm	0:	3286		45		
3 4						1		├					
	IAL CALIE	BRATION				C/	ALIBRATIO	N CH	ECKS				
DATE:		04/11/05	04/11/05	04/	/12/05	04/12/0	05 04/13	3/05	04/13/0	05	04/18	05	04/18/05
TIME:	••	1313	2201	0	846	1455	090)1	1925		084	5	2142
	CTOR /	.050" Notch	,050" Notch		050" lotch	.050* Notci			.050" Noteh	- 1	.050 Note		.050" Notch
	AMPLITUDE	80%/0db	80%/2db	80	%/0db	80%/2	db 80%/	0db	80%/1	db	80%/0	ldb	80%/1db
CH. 1	LOCATION	1.414"	1,397"	1.	414"	1.411	" 1.41	4"	1.411	14	1.41	4"	1.411"
CH. 2	AMPLITUDE	80%/0db	80%/-2dt	80	%/0db	80%/2	db 80%/	0db	80%/10	db	80%/0	db	80%/-2db
. Gn. 2	LOCATION	1.414"	1.407"	1.	.414"	1.411	" 1.41	4"	1.414	"	1.41	4"	1.414"
CH. 3	AMPLITUDE												
	LOCATION		<u> </u>						,				
CH. 4	AMPLITUDE								L				
 	LOCATION												
EXAM		WHN	WHN	ν	VHN	WHN) W	N	WHN	1	WD	P	WDP
Remar CAL													
Examir	ner: W. K	Purdy ,	E	xamin	er: W. H.	Nelso	n	Ī	Reviewer	: W	. H. Ne	Ison	
<u> </u>	<u>ر</u> د	Hund	<u>u_ </u>	W	42	21_		_	W	<u>IJ</u> ,	7 Je	<u></u>	
Level:			25) L	.evel: _	III Dat	e: 4	/11-13/05	ī	evel: <u>I</u>	L	Date:	07/1	7/2005
L	P-Scan Limited												

		IATED UI CALIBRA	TRASOI			4	# doL	04-41		Riser	25
Location:	200 EAS	T TANK F	ARM	Syster	m: 103	AN	Calibration Block:	444-99-3	0-0 0	1/002	
Procedur	re: COGE	MA SVUT-	INS-007.3		Rev.	2	Thickness:	1.0"	М	aterial:	Carbon Steel
UT Syste	em: F	PSP-4	Serial No	٥.	201		Reference Block:			N/A	
Software	Version:	P-SCAN	Sys. 4 1.	3	Rev.	2	Thickness:	N/A	M	laterial:	N/A
Linearity	Due Date:	06/30	/2005				Reference	Block Temp:	ΑN	⁄B °F	
Scanner	Type:	AWS-5d	Serial N	o. 31	0		Couplant:	Water	B	atch No.	N/A
Scanner	Cable:	COAXIAL					Cable Leng	jth:	80 F	eet	
Signal Co	able:	COAXIAL					Cable Leng	jth:	80 F	eet	
Channe		nsducer Make	Model		Freq. (MHz)		Size	Serial No.		e (deg) n. / Act.	Wedge Type
1		КВ	MWB		4	8	x9mm	2-3200		60	
2		KB	MWB		4	8	x9mm	2-3029	 	60	
3									 		
4	AL CALIBI	PATION					LIBBATIO	N CHECKS	<u> </u>		
DATE:	AL CALIBI	05/16/05	05/16/05	06	/18/05	05/18/0		N CHECKS		<u></u>	
TIME:		0953			0935		15				
	CTOR /		1405			2057					
	TATION:	.050" Notch	,050" Notch		050" lotch	.050" Notch					
	AMPLITUDE	80%/0db	80%/1db	80	%/ 0 db	80%/-10	db d				
CH. 1	LOCATION	2.00"	1.999"	7	2.00"	1.993	1				
CH. 2	AMPLITUDE	80%/0db	80%/0db	80	%/0db	80%/10	ib				
	LOCATION	2.00"	1.995*	- 7	2.00"	1.986	•				
CH. 3 -	AMPLITUDE										
	LOCATION	**************************************									
CH. 4	AMPLITUDE			1							
	LOCATION	···									
EXAMI		WDP	WDP	\	NDP	WDP					
Remark CAL.		-									
Examin	er: W. Q.	Purdy	E	xamin	er:		**	Review	er: W	/, H. Ne	lson
<u> </u>	\mathcal{D}'	rud	<u>~</u> _					W	07	Tel	
Level:	<u>II</u> Date an Limited	: 5/16 & 18	3/ 05) Le	evel:	Da	ite:		Level:	111	Date:	07/17/2005
		. Rev. 2. Atlachm	est 3								Rev. Dec. 03, 2003

Att. 2-59

	AUTO	MATED U	LTRASON		-SCAN		Job#	04-41		Riser #	25
Location	n: 200 EA	ST TANK F	ARM	System	1: 103-AN		libration Block:	444-99-3	0-0	01/002	
Procedu	ure: COG	EMA SVUT	INS-007.3	······	Rev. 2		ickness:	1.0"		Material;	Carbon Steel
UT Sys	item:	PSP-4	Serial No).	201		ference Block:			N/A	
Softwar	re Version:	P-SCAN	Sys. 4 1.	3	Rev. 2	Th	ickness:	N/A		Material:	N/A
Linearit	ly Due Date	06/30	/2005			Re	ference	Block Temp:	Α	MB ^o F	
Scanne	er Type:	AWS-5d	Serial No	310)	Co	uplant:	Water		Batch No.	N/A
Scanne	er Cable:	COAXIAL				Ca	ble Leng	gth:	80	Feet	
Signal (Cable:	COAXIAL				Ca	ble Leng	jth:	80 1	Feet	
Chanr	nel Ti	ansducer Make	Model		Freq. (MHz)	Siz	e	Serial No.		gle (deg) m, / Act.	Wedge Type
1		КВ	MWB		4	8x9r	nm	23200		60	
2		KB	MWB		4	8x9r	nm	23029	—	60	
3									+		
	TIAL CALI	BRATION !	1	L		CALIE	RATIO	N CHECKS			
DATE:		06/15/05	06/15/05	T	<u>-</u>	Onch	10000	TOTILORG		1	
TIME:		0920	1320	 							
REFLE	ECTOR /	,050" Notch	.050" Notch								
	AMPLITUDE	80%/0db	80%/-1db	1						1	
CH. 1	LOCATION	2.000"	2,000"					<u> </u>			
CH. 2	AMPLITUDE	80%/0db	80%/-2db								
0,1.2	LOCATION	2.000"	1.996"								
CH. 3	AMPLITUDE										
041.0	LOCATION										
CH. 4	AMPLITUDE										
011. 4	LOCATION										
EXAM	IINER:	WDP	WDP								
Rema CAI	arks: L.P5										
Exami	iner: W. I	D. Purdy	dy E	kamine	er:		****	Review		W. H. Ne	Ison
i	: <u>II</u> Da		05 Le	evel: _	Date:			Level:	<u> </u>	Date:	07/17/2005

COGEMA-SVUT-INS-007.3, Rev. 2, Attachment 3

Rev. Dec. 03, 2003

Job#

Riser#

	AUTON	MATED ULT CALIBRA				SS		Job#		05-41		Riser		25
Location	200 E	AST TANK F	ARM	Syster	^{n:} 103-	AN	1	oration ock:	44	4-99-3 (0-004			
Procedu	re:	GEMA SVUT		.3	Rev.	2		kness:	0.3	" to 1.0	Ma	terial:	Carb	oon Steel
UT Syst	em:	PSP-4	Serial N	lo.	201			rence ock:				N/A		
Software	a Version	P-SCAN	Sys. 4 1	.3	Rev.	2	Thic	kness:	i	N/A	Ma	terial:		N/A
Linearity	/ Due Dat	e: 06/01	/2005				Refe	rence	Block	Temp:	AM	в °F		
Scanner	r Type:	AWS-5d	Serial N	lo. 31	0		Cou	plant:	W	ater	Ba	tch No.	·	N/A
Scanner	r Cable:	COAXIAL					Cab	le Leng	ith:	8	0 Fe	et		
Signal C	Cable:	COAXIAL					Cab	le Leng	th:	8	0 Fe	et		
Chann	ei .	Transducer Make	Mode]	Freq. (MHz)		Size		Ser	ial No.	An (de	- . ,		Wedge Type
1		KB	MSE	3	5	8	3x2Mi	M	0	1931	(
2		*KB	MSE	3	5	8	3x2MI	M	0	1997	(2		
3 4										~				
	IAL CAL	BRATION]		<u> </u>	C	ALIBF	RATIO	N CI	IECKS		<u> </u>		
DATE:		04/11/05	04/11/05	04	/12/05	04/12/	05	04/13	/05	04/13	/05	04/21/	05	04/21/05
TIME:		1309	2158	(837	1452	2	090	5	193	0	082	5	1453
REFLE	CTOR:	.3"-1.0"	.3"-1.0"	.3	"-1.0"	.3"-1.	0"	.3"-1	.0"	.3"-1.	.0"	.3"-1.	0"	.3"-1.0"
CH. 1	THK. 1	.299"	.295"		302"	.309	,,	.29	9"	.298	3"	.302	91	.302"
Crt. 1	THK. 2	1.00"/0db	.997"/ 0 db	1.0	00"/0db	1.008"/	1db	1.00"/	'Odb	.997"/	1db	1.00"/0	db	.997"/0db
CH. 2	THK. 1	.299"	,295"		302"	.309	•	.299	9"	.295	j"	.302	19	.302"
Q.1. Z	THK. 2	1.00"/0db	.997"/0db	1.0)0"/0db	1.008"/	1db	1.00"/	(Odb	.997"/	1db	1.00"/0)db	.997"/0db
CH. 3	THK. 1	.299"	.295"		299"	.306	и	.299	9"	.295	5"	.302		.299"
011.0	THK. 2	1.00°/0db	.997"/0dt	1.0	00"/0db	1.008"/	1db	1.00"/	/Odb	.997"/	0db	1.00"/0	Odb	1.00"/1db
CH. 4	THK. 1													
	THK. 2													
EXAM		WHN	WHN	`	WHN	WH	N	WH	IN	WH	N	WDI	Ρ	WDP
Remai CAL *Tra	_,T1	r #01997 res	can only	on 2 nd	pass p	late 3								
Exami	ner: W	D. Purdy	E	xamir	er: W.	H. Nelso	n			Reviewe	er: W.	H. Ne	son	
1 1 1	TC	1/-7:	$\perp L.L$	111	41	2/01				WE	17	7.	_	
Level:	<u>II</u> C)ate: 4/21/	05	_evel:	<u> </u> D	ate:	1/11-1	3/05	***	Level: _	<u> </u>	Date:	07/1	7/2005
COGEMA	-SVUT-INS-	907.3, Rev. 2, Altechi	nent 1										Re	v. Dec. 03, 2003

,	AUTOM	ATED ULT CALIBRA				SS	Job :	#	04-41		Riser		25
Location	1: 200 EA	ST TANK F	ARM	Syster	n: 103-	AN	Calibration	n 44	4-99-30	-004			
Procedu	re: CO	GEMA SVUT	-INS-007	7.3	Rev.	2	Thickness	0.3	" to 1.0"	Mat	erial:	Cart	on Steel
UT Syst	em:	PSP-4	Serial I	No.	405		Reference Block:	3			N/A		
Softwar	e Version:	P-SCAN	Sys. 4	1.3	Rev.	2	Thickness	¥.	N/A	Mat	terial:		N/A
Linearit	y Due Date	06/30	/2005		········		Reference	Block	Temp:	AME	3 ^o F		
Scanne	r Type:	AGS-2	Serial I	No. 40	1		Couplant:	٧	/ater	Bat	ch No.		N/A
Scanne	r Cable:	COAXIAL					Cable Ler	ngth:	10	0 Fee	et		
Signal (Cable:	COAXIAL					Cable Ler	igth:	10) Fee	et		
Chann	ei T	ransducer Make	Mode	el	Freq. (MHz)		Size	Se	rial No.	Ang (de			Wedge Type
1		KB	MSE	В	5		x2MM	0	1997	0			
2		кв	MSE	В	5	9	x2MM	0	2002	0			
3													
4													
TINI	TAL CALI	BRATION			·	C/	LIBRATI	ON CI	HECKS				
DATE:	···	04/13/05	04/13/05	5 04/	13/05	04/13/0	05 04/1	4/05	04/14/	05	04/14/	05	04/14/05
TIME:		1004	1014	2	034	2034	30	31	0837		1531	<u> </u>	1534
REFLE	CTOR:	.3"-1.0"	.3"-1.0"	.3	'-1.0"	.3"-1.0	.3"-	1.0"	.3"-1.0)"	3"-1.	0"	.3"-1.0"
CH. 1	THK. 1	.301"	.301"		293"	.296'	.3	03"	.303	•	.298	•	.298"
	THK. 2	1.00"/0db	1.00"/0di	b .992	2"/-1db	.995"/1	db 1.00	"/0db	1.00"/0	db	.995"/0	db	.995"/0db
CH. 2	THK. 1	.301"	.301"		296"	.296"	.2	98"	.301	•	.296	*	.298"
	THK. 2	1.00"/0db	1.00"/0d	ь .99	5"/0db	.995"/1	db 1.00	"/0db	1.00"/0	db │	.997"/0	db	.995"/0db
CH. 3	THK. 1	.301"	.301"		296"	.296'	31	01"	.301	·	.296	"	.298"
	THK. 2	1.00"/0db	1.00"/0dl	b .99	5"/0db	.995"/1	db 1.00	"/0db	1.00"/0	dЬ	.997"/0	db	.995"/0db
CH, 4	THK. 1		<u></u>										
	THK. 2	 	<u> </u>						ļ				
EXAM		WHN	WHN	V	VHN	WHN	_ w	HN	WHN	<u> </u>	WHN	4	WHN
Remar													,
Examir	ner: W. I	I. Nelson		Examine	er:			Į i	Reviewer	- W	H Nai	500	
a		John	·						CH	_	701	2	
Level:	<u>III</u> Da	te: 4/13-14	/05 1	_evel: _	Da	te:			_evel: _ii		ate:	07/1	7/2005

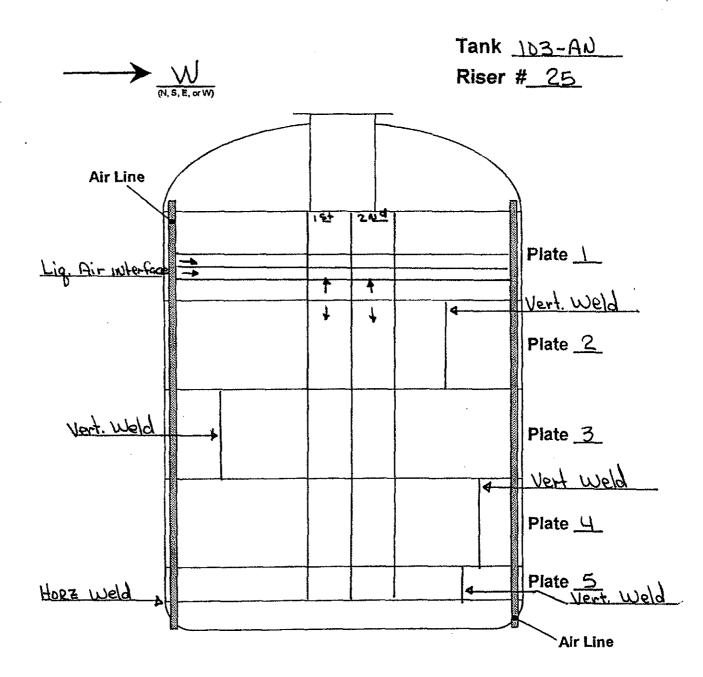
COGEMA-SVUT-INS-007.3, Rev. 2, Attachment 1

Rev. Dec. 03, 2003

AU	TOMA	TED ULT CALIBRA				ESS		J00 #		04-41		Risei		25
Location: 2	00 EAS	ST TANK FA	\RM	Syste	m: 103-	-AN		bration lock:	44	4-99-30	-004	.		
Procedure:	COG	EMA SVUT	-INS-007	.3	Rev.	2	Thic	kness:	0.3	" to 1.0'	, Ma	terial:	Cart	oon Steel
UT System	: 1	PSP-4	Serial N	lo.	201			erence lock:				N/A		
Software V	ersion:	P-SCAN	Sys. 4 1	.3	Rev.	2	Thic	kness:		N/A	Ma	terial:		N/A
Linearity D	ue Date:	06/30	2005		_ -		Ref	erence	Block	Temp:	AMI	в ^о ғ		
Scanner Ty	/pe:	AWS-5d	Serial N	٧٥.	310)	Cou	ıplant:	310	Water	Bat	tch No.		N/A
Scanner C	able:	COAXIAL					Cab	le Leng	th:	8	0 Fe	et		
Signal Cab	le:	COAXIAL					Cab	le Leng	th:	8	0 Fe	et	····	
Channel		insducer Make	Mode	ŀ	Freq.		Size		Ser	rial No.	Ang (de			Wedge Type
1		KB	MSE	3	5		x2M	М	0	1939	(.,,,,,
2		КВ	MSE	В	5	9	x2M	М	0	1997	()		
3	-					 								
4	CALIB	DATION			<u> </u>		LIDI	DATIO	N.C.	HECKS				
DATE:	CALIB	05/16/05	05/16/05	05	/16/05	05/16/0		05/18		05/18/	06	05/18	ins	05/18/05
TIME:	·····	0928	0935		1355	1357	\rightarrow	091		092		204		2053
REFLECT	OR:	.3"-1.0"	3"-1.0"		"-1.0"	.3"-1.0		3"-1		.3"-1.		.3"-1.		.3"-1.0"
π, π	HK. 1	.298"	.304"	<u> </u>	298"	.301*		.302	2"	.298		.282	···	.295"
CH. 1	IK. 2	1.00"/0db	1.00"/0db	.99	9"/-1db	.999"/00	db	1.00"/	0db	1.00"/0	Odb	.986"/-	2db	.996"/1db
Д., Д. Т.	HK. 1	.298"	.304"	<u> </u>	298"	.304"		.30	2"	.298	"	.282	2"	.295"
CH. 2	HK. 2	1.00"/0db	1.0070dt	.99	6"/-1db	1.002"/-1	1db	1.007/	(Odb	1.00%	Odb	.983"/-	1db	.999"/1db
CH. 3	HK. 1	.301"	.304"		304"	.301"		.30	2"	.298	J.*	.288	3"	.295"
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COGEMA-SVUT-INS-007 3, Rev 2, Attachment 1

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ATTACHMENT 3

ULTRASONIC EXAMINATION OF DOUBLE-SHELL TANK 241-AN-103 EXAMINATION COMPLETED JUNE 2005 (PNNL THIRD PARTY REVIEW) This page intentionally left blank.

Ultrasonic Examination of Double-Shell Tank 241-AN-103 Examination Completed June 2005

AF Pardini GJ Posakony

July 2005

Prepared for the U.S. Department of Energy under Contract DE-AC05-76RL01830

Pacific Northwest National Laboratory Richland, Washington 99352

Summary

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination of selected portions of Double-Shell Tank 241-AN-103. The purpose of this examination was to provide information that could be used to evaluate the integrity of the wall of the primary tank. The requirements for the ultrasonic examination of Tank 241-AN-103 were to detect, characterize (identify, size, and locate), and record measurements made of any wall thinning, pitting, or cracks that might be present in the wall of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-22571 (Jensen 2004) and summarized on page 1 of this document, are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA ultrasonic examinations.

Examination Results

The results of the examination of Tank 241-AN-103 have been evaluated by PNNL personnel. The ultrasonic examination consisted of two 15-in. wide scan paths over the entire height of the tank and the heat-affected zone (HAZ) of four vertical welds and one horizontal weld. The examination also includes two horizontal scan paths in the liquid/air interface region on Plate #1. The examination was performed to detect any wall thinning, pitting, or cracking in the primary tank wall.

Primary Tank Wall Vertical Scan Paths

Two 15-in.-wide vertical scan paths were performed on Plates #1, #2, #3, #4, and #5. The plates were examined for wall thinning, pitting, and cracks oriented vertically on the primary tank wall. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or vertical crack-like indications were detected in Plates #1, #2, #3, #4, or #5.

Primary Tank Wall Weld Scan Paths

The HAZ of vertical welds in Plates #2, #3, #4, and #5 were examined for wall thinning, pitting, and cracks oriented either perpendicular or parallel to the weld. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld HAZ areas in Plates #2, #3, #4, and #5.

The HAZ of the horizontal weld between Plate #5 and the tank knuckle was examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld HAZ areas on Plate #5 side or on the knuckle side of the horizontal weld.

Primary Tank Wall Liquid/Air Interface Horizontal Scan Paths

Two 17-in.-wide scan paths were performed on Plate #1. The plate was examined for wall thinning on the primary tank wall. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness.

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1.0 Introduction

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination (UT) of selected portions of Double-Shell Tank (DST) 241-AN-103. The purpose of this examination was to provide information that could be used to evaluate the integrity of the DST. The requirements for the UT of Tank 241-AN-103 were to detect, characterize (identify, size, and locate), and record measurements made of any wall thinning, pitting, or cracks that might be present in the wall of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-22571 (Jensen 2004), are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Specific measurements that are reported include the following:

- Wall thinning that exceeds 10% of the nominal thickness of the plate.
- Pits with depths that exceed 25% of the nominal plate thickness.
- Stress-corrosion cracks that exceed 0.10 in. (through-wall) and are detected in the inner wall of the tank, HAZ of welds, or in the tank knuckle.

The accuracy requirements for ultrasonic measurements for the different types of defects are as follows:

- Wall thinning measure thickness within ± 0.020 in.
- Pits size depths within ± 0.050 in.
- Cracks size the depth of cracks on the inner wall surfaces within ± 0.1 in.
- Location locate all reportable indications within ± 1.0 in.

Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA UT.

2.0 Qualified Personnel, Procedures, and Equipment

Under contract from CH2M Hill, qualification of personnel participating in the DST inspection program, the UT equipment (instrument and mechanical scanning fixture), and the UT procedure that will be used in the examination of the current DST is required. Personnel participating in the examinations are to be certified in accordance with American Society for Nondestructive Testing (ASNT) Recommended Practice SNT-TC-1A, 1992 Edition, and associated documentation is to be provided. The capability of the UT system is to be validated through a performance demonstration test (PDT) on a mock-up simulating the actual DST. The current procedure for the UT is to be based on requirements listed in the American Society for Mechanical Engineers (ASME), Boiler and Pressure Vessel Code Section V, Article 4, *Ultrasonic Examination Methods for Inservice Inspection*.

2.1 Personnel Qualifications

The following individuals were qualified and certified to perform UT of the Hanford DST 241-AN-103:

- Mr. Wesley Nelson, ASNT Level III (#LM-1874) in UT, has been identified as COGEMA's UT Level III authority for this project. Mr. Nelson has been certified by COGEMA as a UT Level III in accordance with COGEMA procedure COGEMA-SVCP-PRC-014, latest revision. Further documentation has been provided to establish his qualifications. Reference: Letter from PNNL to C.E. Jensen dated August 22, 2000, "Report on Performance Demonstration Test PDT, May 2000."
- Mr. James B. Elder, ASNT Level III (#JM-1891) in UT, has been contracted by COGEMA to provide
 analysis of all DST UT data. Mr. Elder has been certified by JBNDT as a UT Level III in accordance with
 JBNDT written practice JBNDT-WP-1, latest revision. Further documentation has been provided to establish
 his qualifications. Reference: PNNL-11971, Final Report Ultrasonic Examination of Double-Shell Tank
 241-AN-107.
- Mr. William D. Purdy, COGEMA UT Level II limited (for P-Scan data acquisition only). Mr. Purdy has been certified in accordance with COGEMA procedure COGEMA-SVCP-PRC-014, latest revision. Further documentation has been provided to establish his qualifications. Reference: Letter from PNNL to C.E. Jensen dated October 5, 2001, "Purdy Performance Demonstration Test (PDT) Report."

2.2 Ultrasonic Examination Equipment

CH2M Hill has provided the UT equipment for the examination of Tank 241-AN-103. This equipment consists of a Force Institute P-Scan ultrasonic test instrument and a Force Institute AWS-5D and AGS-2 remote-controlled, magnetic-wheel crawlers for examining the primary tank wall. Ultrasonic transducers used for the examinations are commercial off the shelf. The P-Scan ultrasonic system has been qualified through a PDT. Reference: PNNL-11971, Final Report- Ultrasonic Examination of Double-Shell Tank 241-AN-107.

2.3 Ultrasonic Examination Procedure

COGEMA-SVUT-INS-007.3, Revision 2, outlines the type of UT and mechanical equipment that are to be used as well as the types of transducers. Both straight-beam and angle-beam transducers are used for the examination of the primary tank wall. The examination procedures include full documentation on methods for calibration, examination, and reporting. Hard copies of the T-Scan (thickness) and P-Scan (projection or angle beam) views of all areas scanned are made available for analysis. The UT procedure requires the use of specific UT transducers for the different examinations. A calibration performed before and after the examinations identifies the specific transducers used and the sensitivity adjustments needed to perform the inspection. The COGEMA UT procedure has been qualified through a Performance Demonstration Test. Reference: PNNL-11971, Final Report - Ultrasonic Examination of Double-Shell Tank 241-AN-107.

3.0 Ultrasonic Examination Configuration

COGEMA is required to inspect selected portions of the DSTs which may include the primary and secondary tank walls, the HAZ of the primary tank vertical and horizontal welds, and the tank knuckle and bottoms. The P-Scan system has been configured to perform these examinations and has been performance tested. The examination of Tank 241-AN-103 included UT of the primary tank wall and the HAZ of selected welds in the primary tank wall.

3.1 Primary Tank Wall Transducer Configuration

Figure 3.1 provides an example of the scanning configuration generally used during an examination of the primary tank wall. However, other configurations can be used at the discretion of the COGEMA UT Level III (i.e., 45-degree transducers can be removed for simple wall thickness measurements). The functional diagram in Figure 3.1 shows one straight-beam and two angle-beam transducers ganged together for examining the primary tank wall. The straight beam is designed to detect and record wall thinning and pits, and the angle beams are designed to detect and record any cracking that may be present. These transducers are attached to the scanning bridge and they all move together. Information is captured every 0.035-in. (or as set by the NDE inspector) as the assembly is scanned across a line. At the end of each scan the fixture is indexed 0.035-in. (or as set by the NDE inspector) and the scan is repeated. The mechanical scanning fixture is designed to scan a maximum of 15-in. and then index for the next scan. The hard copy provides a permanent record that is used for the subsequent analysis.

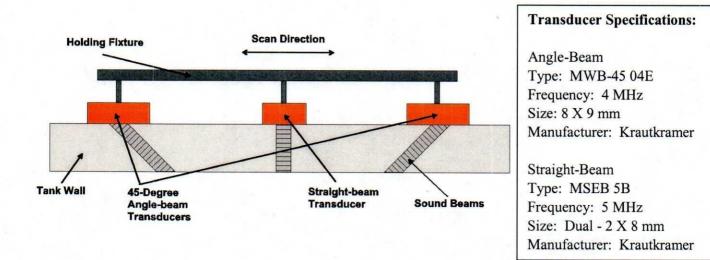


Figure 3.1. Transducer Configuration for Examining the Primary Tank Wall

3.2 Weld Zone Transducer Configuration

Figure 3.2 is a functional sketch that shows the configurations for examination of the weld zone. The area of interest (HAZ of the weld) is shown as lying adjacent to the weld. Both cracks and pitting may occur in this region. The "A" portion of this sketch shows the 60-degree angle-beam transducers used for detecting cracks parallel to the weld. The straight-beam transducers in this sketch are used for detecting and recording any pitting or wall thinning that may be present. All transducers are ganged together. The scanning distance traveled is limited to a total of approximately 5.0-in. The sketch titled "B" shows the arrangement for detecting cracks that may lie perpendicular to the weld. Four 45-degree, angle-beam transducers are used for this inspection. Again the transducers are ganged together but the scan is limited to a total of approximately 4.0-in. The weld zone requirements are shown in Figure 3.3. The scan protocol, data capture, and index are the same for examining other weld areas in the tank.

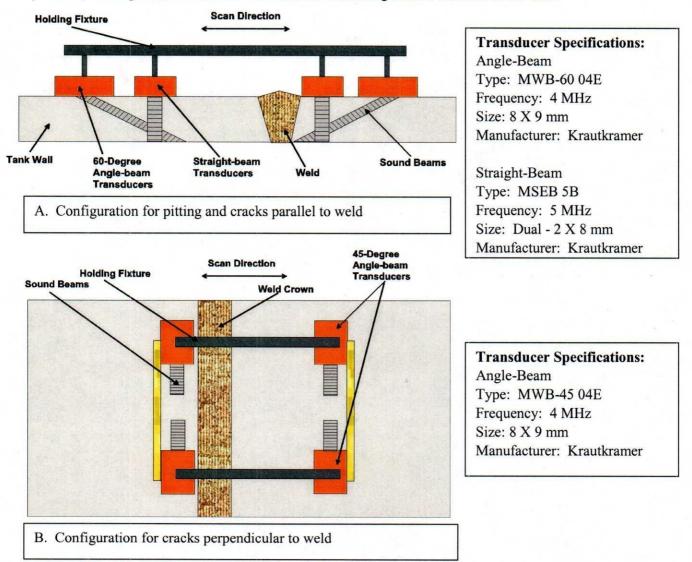
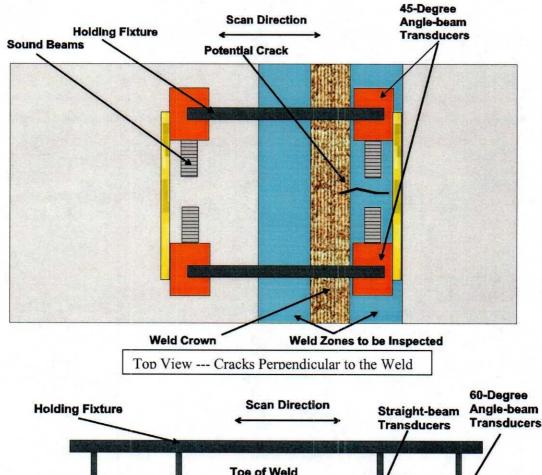
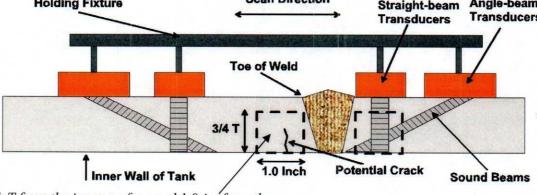


Figure 3.2. Transducer Configurations for Examination of Weld Zone in the Primary Tank Wall

In the HAZ, the requirement for characterizing cracks that lie perpendicular or parallel to welds in the primary tank wall is described in Figure 3.3. The HAZs are located on either side of the weld and defined as being within 1-in. of the toe of the weld and on the inner three-quarters of the thickness (3/4T) of the plate. These zones are considered most likely to experience stress-corrosion cracking.





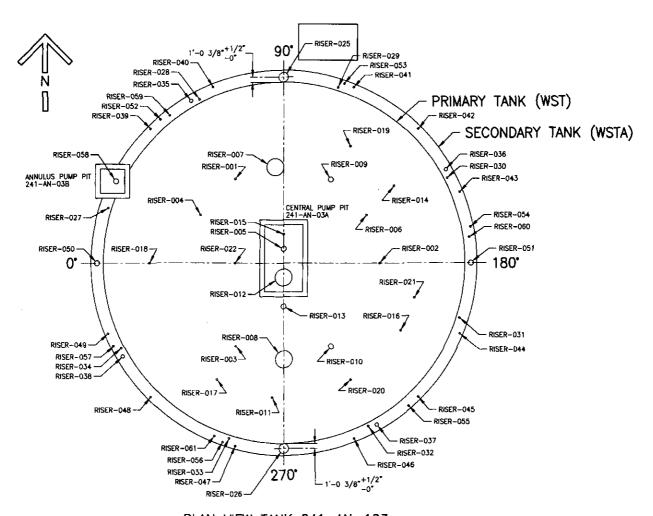
A zone ¾ T from the inner surface and 1.0-in. from the toe of the weld is to be ultrasonically examined for cracking, corrosion or pitting. Examinations are to be made on both sides of the weld.

End View --- Cracks Parallel to the Weld

Figure 3.3. Views of the Weld Zone to be Ultrasonically Examined in the Primary Tank Wall

4.0 Ultrasonic Examination Location

Tank 241-AN-103 is located in the Hanford 200 East area in AN Tank Farm. The crawler and associated scanner were lowered into the 24-in. riser located on the north side of 241-AN-103 and designated as Riser 25. Figure 4.1 provides a graphic of the location of this riser.



PLAN VIEW TANK 241-AN-103

Figure 4.1. UT of 241-AN-103 Riser 25

Figure 4.2 describes the areas on the primary wall of Tank 241-AN-103 that were ultrasonically examined. Two 15-in.-wide vertical scan paths were performed on Plates #1, #2, #3, #4, and #5 below the entrance to Riser 25. Vertical weld HAZ examinations were done on Plates #2, #3, #4, and #5, and the horizontal weld HAZ examination was done on the transition Plate #5 to knuckle weld. Two additional horizontal scan paths were performed in the liquid/air interface region on Plate #1.

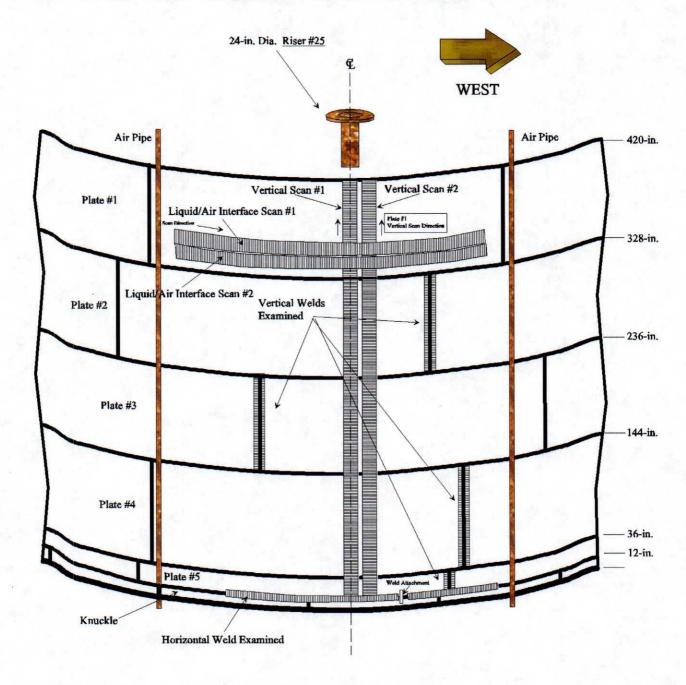


Figure 4.2. Sketch of Scan Paths on Tank 241-AN-103

5.0 Ultrasonic Examination Results

COGEMA has provided detailed reports including T-Scan and P-Scan hard copies of all areas that were ultrasonically examined to PNNL for third-party review. The data was analyzed by JBNDT Level III Mr. Jim Elder and peer reviewed by COGEMA Level III Mr. Wes Nelson. The results of the examination of Tank 241-AN-103 are presented in Figures 5.1 and 5.2.

Figures 5.1 and 5.2 show the wall thickness examination results for the primary tank wall and the HAZs of both vertical and horizontal welds. The examination consisted of two vertical paths beneath the 24-in. diameter riser. Vertical scan #1 was 15-in. wide on Plate #1, #2, #3, #4, and #5 near the centerline of the 24-in. riser. Vertical scan #2 was adjacent to vertical scan #1 and was also 15-in. wide on Plate #1, #2, #3, #4, and #5. Vertical scans on Plate #1 were done in the upward direction due to modifications made to the crawler cable attachment. All other plates were done in the downward direction. The HAZs of vertical welds in Plates #2, #3, #4, and #5 were examined and the HAZ in the horizontal weld between Plate #5 and the knuckle section was also examined. Weld area exams include approximately 5-in. on each side of the weld. Two 17-in. wide horizontal scan paths on Plate #1 were performed in the liquid/air interface region. Areas in the figures that show two measurements in the same box are the result of the vertical scan paths overlapping the horizontal scan paths. Figures 5.1 and 5.2 display the minimum readings taken in each 15-in. (17-in. for the liquid/air interface horizontal scans) wide by 12-in. long area of the scan. In the overlapping areas, both minimum readings from each vertical and horizontal scan paths are given. One area on the horizontal weld examination had a weld attachment that limited data acquisition. This area is designated with a NR for "no reading".

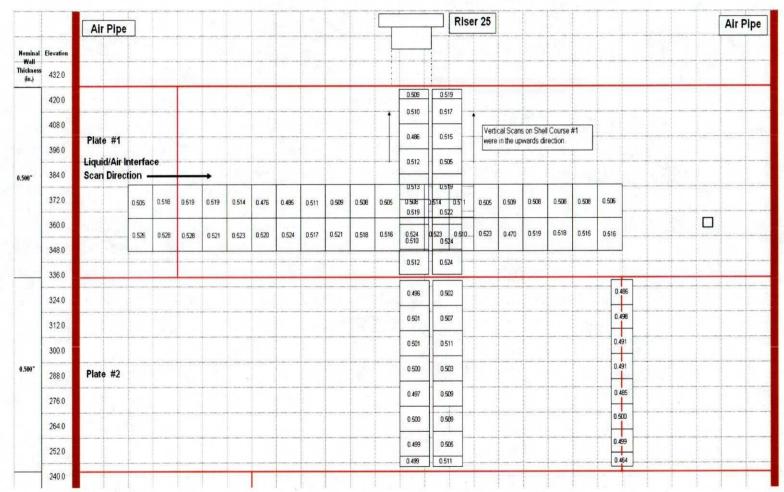
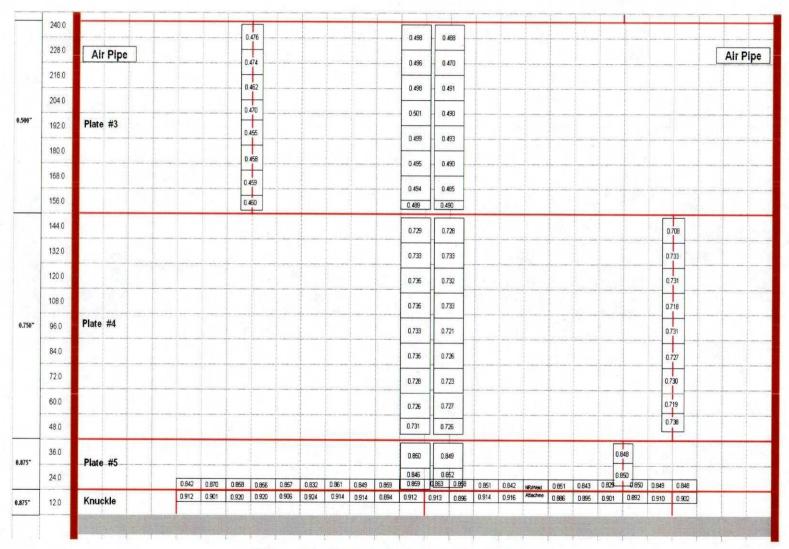


Figure 5.1. UT Data from Tank 241-AN-103



11 Att. 3-19

Figure 5.2 UT Data from Tank 241-AN-103 cont.

6.0 Conclusions

The results of the examination of Tank 241-AN-103 have been evaluated by PNNL personnel. The examination consisted of two 15-in. wide scans over the entire height of the tank and the HAZs of 4 vertical welds and 1 horizontal weld. The examination also included two 17-in. wide scans in the liquid/air interface region on Plate #1. The examination was performed to detect any wall thinning, pitting, or cracking in the primary tank wall.

6.1 Primary Tank Wall Vertical Scan Paths

Two 15-in.-wide scan paths were performed on Plates #1, #2, #3, #4, and #5. The plates were examined for wall thinning, pitting, and cracks oriented vertically on the primary tank wall. The results indicated that the minimum thicknesses in the areas scanned with nominal thickness of 0.500-in. were as follows; Plate #1 was 0.486-in., Plate #2 was 0.496-in., and Plate #3 was 0.470-in. The nominal thickness in Plate #4 is 0.750-in. and the minimum thickness in this area was 0.721-in. The nominal thickness in Plate #5 is 0.875-in. and the minimum thickness in this area was 0.846-in. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or vertical crack-like indications were detected in Plates #1, #2, #3, #4, or #5.

6.2 Primary Tank Wall Weld Scan Paths

The HAZ of vertical welds in Plates #2, #3, #4, and #5 were examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. The results indicated that the minimum thicknesses in the weld areas scanned were as follows: The nominal thickness of Plate #2 is 0.500-in. and the minimum thickness in this weld area was 0.464-in. The nominal thickness in Plate #3 is 0.500-in. and the minimum thickness in this weld area was 0.455-in. The nominal thickness in Plate #4 is 0.750-in. and the minimum thickness in this weld area was 0.708-in. The nominal thickness in Plate #5 is 0.875-in. and the minimum thickness in this weld area was 0.848-in. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas in Plates #2, #3, #4, and #5.

The HAZ of the horizontal weld between Plate #5 and the tank knuckle was examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. The results indicated that the minimum thickness in the weld area with nominal thickness of 0.875-in. on Plate #5 was 0.829-in. The minimum thickness in the weld area with nominal thickness of 0.875-in. on the knuckle was 0.886-in. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas on Plate #5 side or on the knuckle side of the horizontal weld.

6.3 Primary Tank Wall Liquid/Air Interface Horizontal Scan Paths

Two 17-in.-wide scan paths were performed on Plate #1. The plate was examined for wall thinning on the primary tank wall. The results indicated that the minimum thickness in the areas scanned on Plate #1 with nominal thickness of 0.500-in. was 0.470-in. There were no areas of wall thinning that exceeded the reportable level of 10% of the nominal thickness.

7.0 References

Jensen, C. E., 2004, Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks FY2005, RPP-22571, Rev 0, September 2004, CH2M Hill Hanford Group,

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